



# AMWELD®

BUILDING PRODUCTS



STEEL DOORS

AND FRAMES

Standard Types and Sizes • Distinctive Style and Variety  
For Commercial, Institutional and Residential Buildings

PLANT STREET, NILES, OHIO

A Division of The American Welding & Manufacturing Co., Warren, Ohio



## series 200

# Commodity Line frame construction

With Amweld Inter-Lok frames, door openings can be framed in minutes. Jambs and header are self-aligning and tabs bend over, interlocking to form secure neatly mitered corner.

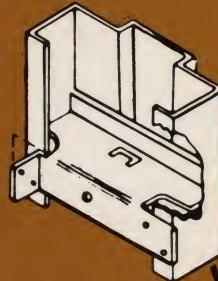
Available in a wide assortment of profiles, there is an Inter-Lok frame for almost every type of wall construction. Snap-in steel anchors provide rigid attachment to studs. Adjustable "T" anchors provide secure attachment of frames in masonry walls.

For 1 $\frac{3}{8}$ " doors, frames are made of 16 or 18 ga. steel; for 1 $\frac{3}{4}$ " doors, frames are made of 16 ga. steel only. All U.L. frames are of 16 ga. Trimmed opening frames, folding door frames and motel interconnecting frames are of 18 ga. steel only.

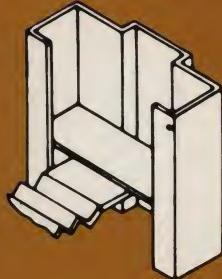
**trimmed openings** (18 gauge only). Trimmed opening frames are available "knocked-down" (Inter-Lok) or assembled. Assembled trimmed openings can be furnished welded with mitered corners.

## inter-lok frame details

FIELD INSERTED STUD ANCHOR  
(1 $\frac{3}{8}$ " and 1 $\frac{3}{4}$ ")



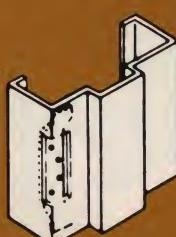
FIELD INSERTED MASONRY ANCHOR (1 $\frac{3}{8}$ " AND 1 $\frac{3}{4}$ ")



1 $\frac{3}{8}$ " FRAME HAS  
TWO 3 $\frac{1}{2}$ " x 3 $\frac{1}{2}$ " HINGES  
WELDED IN PLACE  
OR IS PREPARED TO  
RECEIVE ONE PAIR OF  
3 $\frac{1}{2}$ " x 3 $\frac{1}{2}$ " TEMPLATE OR  
NON-TEMPLATE HINGES



1 $\frac{3}{4}$ " FRAME MORTISED,  
DRILLED AND TAPPED FOR  
4 $\frac{1}{2}$ " x 4 $\frac{1}{2}$ " TEMPLATE  
HINGES (1 $\frac{1}{2}$  PAIR)



RUGGED INTER-LOK  
CORNER CONSTRUCTION  
—NEAT MITERED JOINT



RUBBER  
BUMPER MUTES

STANDARD FLOOR  
ANCHOR DETAIL



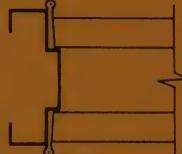
All exposed surfaces of both doors and frames are first chemically cleaned, then factory painted, under controlled conditions, with baked-on zinc chromate primer, for maximum resistance to rust and corrosion. We recommend finish painting with oil base, spirit-thinned, semi-gloss enamel.

## "K-D" inter-lok frames

Commodity Line 1 $\frac{3}{4}$ " frames are formed from 16 gauge and 1 $\frac{3}{4}$ " frames from 16 or 18 gauge steel. Frames are furnished knocked-down for easy handling and economical shipping. Easy to erect—take only minutes to install in stud or masonry walls. Corners are mitered, presenting neat joints. Available in single and double widths. On special order, frames may be furnished assembled with corners welded.

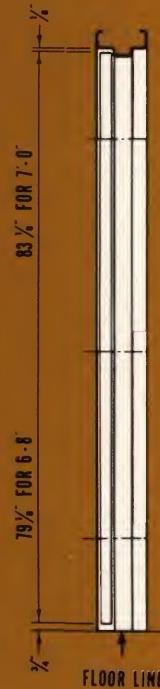
## motel inter-connecting frames

(18 gauge only)



Frames for inter-connecting 1 $\frac{3}{4}$ " motel doors (6 $\frac{1}{4}$ " jamb only) have 1 pair, 3 $\frac{1}{2}$ " x 3 $\frac{1}{2}$ " welded hinges on both rabbets of hinge jamb and strike preparation on both rabbets of strike jamb.

## rust-inhibitive finish



# series 200 Commodity Line

## frame profiles

sizes available.  
④ — Underwriters' Label



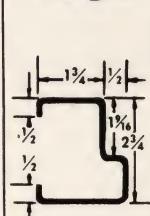
16b  
Amw

Types and sizes in shaded blocks are available in Single Frames for fast de-

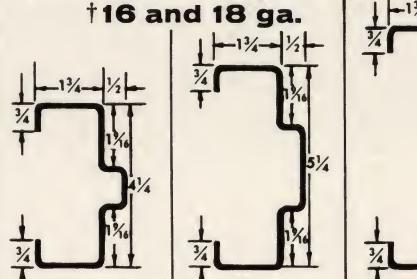
livery. On 1 3/8" Frames, this applies when frame is prepared for 161 Series strike.

**1 3/8"**  
frames

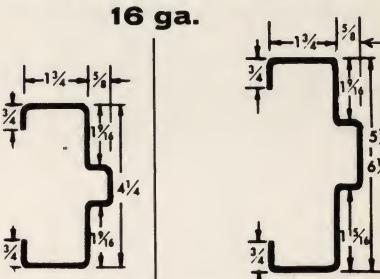
**plaster  
walls  
18 ga.**



**stud or masonry walls  
† 16 and 18 ga.**



**underwriters' label frames  
16 ga.**



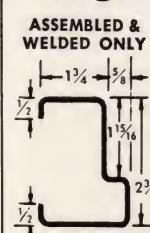
| FRAME HGT. | SINGLE OP. | DOUBLE OP. | 2 3/4" | 4 1/4" | 5 1/4" | 6 1/4" | 4 1/4" | 5 1/4" | 6 1/4" |
|------------|------------|------------|--------|--------|--------|--------|--------|--------|--------|
| 6' 8"      | 1' 6"      |            |        |        |        |        |        |        |        |
|            | 2' 0"      | 4' 0"      |        |        |        |        |        |        |        |
|            | 2' 4" ④    |            |        |        |        |        |        |        |        |
|            | 2' 6" ④    | 5' 0"      |        |        |        |        |        |        |        |
|            | 2' 8" ④    | 5' 4"      |        |        |        |        |        |        |        |
|            | 3' 0" ④    | 6' 0"      |        |        |        |        |        |        |        |
| 7' 0"      | 1' 6"      |            |        |        |        |        |        |        |        |
|            | 2' 0"      | 4' 0"      |        |        |        |        |        |        |        |
|            | 2' 4"      |            |        |        |        |        |        |        |        |
|            | 2' 6"      | 5' 0"      |        |        |        |        |        |        |        |
|            | 2' 8"      | 5' 4"      |        |        |        |        |        |        |        |
|            | 3' 0"      | 6' 0"      |        |        |        |        |        |        |        |

\*Available in motel type frames but not on fast delivery basis.

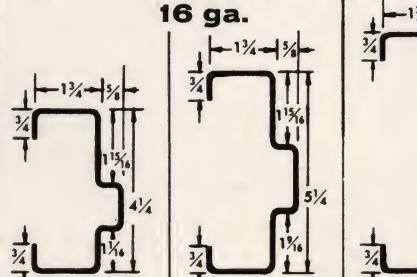
+16 GA. FRAMES SAME CONTOUR AS UL FRAMES

**1 3/4"**  
frames

**plaster  
walls  
16 ga.**

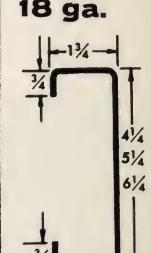


**stud or masonry walls  
16 ga.**



**trimmed opening  
frames**

**stud or  
masonry  
walls  
18 ga.**



| FRAME HGT. | SINGLE OP. | DOUBLE OP. | 2 3/4" | 4 1/4" | 5 1/4" | 6 1/4" |
|------------|------------|------------|--------|--------|--------|--------|
| 6' 8"      | 2' 0"      | 4' 0"      |        |        |        |        |
|            | 2' 4"      |            |        |        |        |        |
|            | 2' 6" ④    | 5' 0"      |        |        |        |        |
|            | 2' 8" ④    | 5' 4"      |        |        |        |        |
|            | 3' 0" ④    | 6' 0"      |        |        |        |        |
|            | 3' 4" ④    | 6' 8"      |        |        |        |        |
|            | 3' 6" ④    | 7' 0"      |        |        |        |        |
| 7' 0"      | 2' 0"      | 4' 0"      |        |        |        |        |
|            | 2' 4"      |            |        |        |        |        |
|            | 2' 6" ④    | 5' 0"      |        |        |        |        |
|            | 2' 8" ④    | 5' 4"      |        |        |        |        |
|            | 3' 0" ④    | 6' 0"      |        |        |        |        |
|            | 3' 4" ④    | 6' 8"      |        |        |        |        |
|            | 3' 6" ④    | 7' 0"      |        |        |        |        |

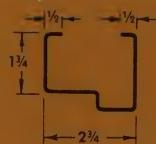
Underwriters' Label 1 3/4" Frames available for fast delivery in 3' 0" widths only with Series 161 strike preparation (5 1/4", 6 1/4" thickness) 6' 8" and 7' 0" high.

| FRAME HGT. | OP.   | 2 3/4" | 4 1/4" | 5 1/4" | 6 1/4" |
|------------|-------|--------|--------|--------|--------|
| 6' 8"      | 2' 0" |        |        |        |        |
|            | 2' 4" |        |        |        |        |
|            | 2' 6" |        |        |        |        |
|            | 2' 8" |        |        |        |        |
|            | 3' 0" |        |        |        |        |
|            | 4' 0" |        |        |        |        |
|            | 5' 0" |        |        |        |        |
|            | 5' 4" |        |        |        |        |
|            | 6' 0" |        |        |        |        |



Commodity Line

## frames in typical wall sections



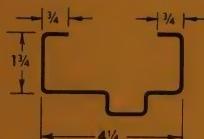
**2 3/4" frames**  
(3 1/4" frames also available)



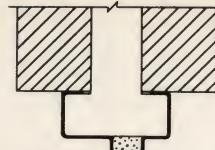
2 3/4" FRAME IN 2" & 2 1/2"  
ROCK LATH & PLASTER WALL



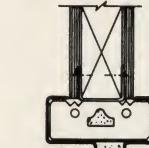
2 3/4" FRAME IN 2" & 2 1/2"  
METAL LATH & PLASTER WALL



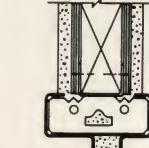
**4 1/4" frames**



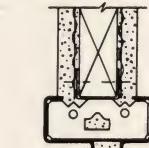
4 1/4" FRAME IN 6" OR 8"  
CONCRETE BLOCK, OR BRICK WALL



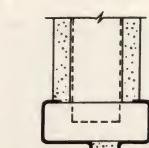
4 1/4" FRAME IN 1 5/8" STUD  
& 1/2" DRY WALL



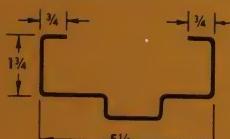
4 1/4" FRAME IN 1 5/8" STUD,  
ROCK LATH & 3/8" PLASTER WALL



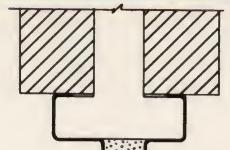
4 1/4" FRAME IN 2" PYROBAR®  
& 3/4" PLASTER WALL



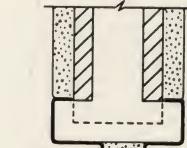
4 1/4" FRAME IN 2" STEEL STUD,  
METAL LATH & 3/4" PLASTER WALL



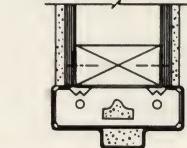
**5 1/4" frames**



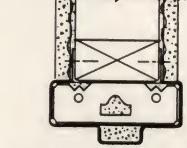
5 1/4" FRAME IN 6" OR 8"  
CONCRETE BLOCK, OR BRICK WALL



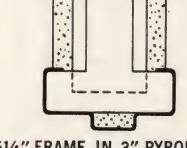
5 1/4" FRAME IN 3 5/8" BLOCK  
WALL, WITH TILE OR PLASTER



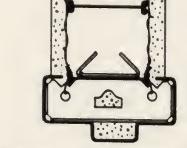
5 1/4" FRAME IN 3 5/8" STUD,  
ROCK LATH & 3/8" PLASTER WALL



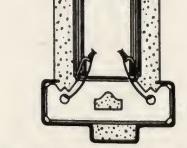
5 1/4" FRAME IN 3 5/8" STUD,  
METAL LATH & 3/4" PLASTER WALL



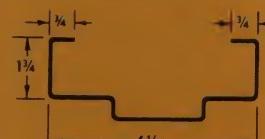
5 1/4" FRAME IN 3" PYROBAR®  
& 3/4" PLASTER WALL



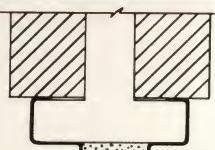
5 1/4" FRAME IN 3 1/4" STEEL STUD,  
METAL LATH & 3/4" PLASTER WALL



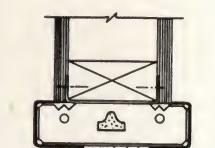
5 1/4" FRAME IN 2 1/2" STEEL STUD,  
3/8" ROCK LATH & 3/4" PLASTER WALL



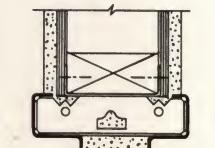
**6 1/4" frames**



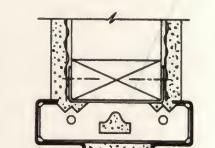
6 1/4" FRAME IN 8" CONCRETE  
BLOCK OR BRICK WALL



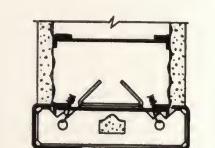
6 1/4" FRAME IN 3 5/8" STUD &  
1/2" DRY WALL



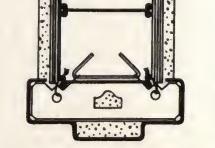
6 1/4" FRAME IN 3 5/8" STUD,  
ROCK LATH & 1/2" PLASTER WALL



6 1/4" FRAME IN 3 5/8" STUD,  
METAL LATH & 3/4" PLASTER WALL



6 1/4" FRAME IN 4" STEEL STUD,  
METAL LATH & 3/4" PLASTER WALL



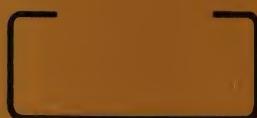
6 1/4" FRAME IN 3 1/4" STEEL STUD,  
3/8" ROCK LATH & 1/2" PLASTER WALL

18 gauge trimmed opening

available in 2 3/4", 4 1/4", 5 1/4"

& 6 1/4" profiles, and for all wall

conditions shown.



18 gauge trimmed opening

available in 2 3/4", 4 1/4", 5 1/4"

& 6 1/4" profiles, and for all wall

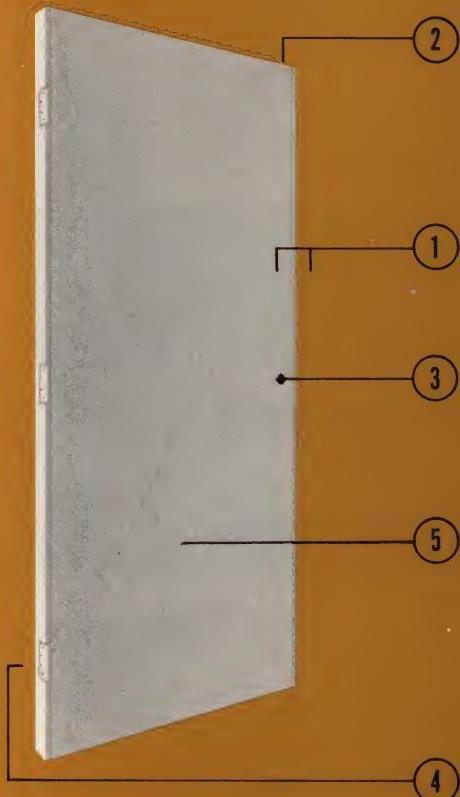
conditions shown.

# series 100 Commodity Line doors

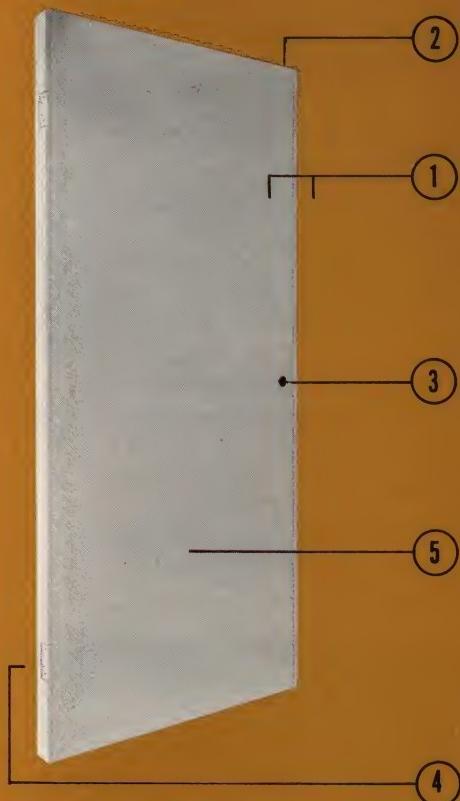


16b  
Amw

**1 3/4"**



**1 3/8"**

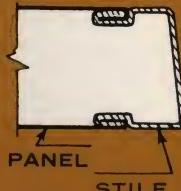


## sturdy welded steel construction

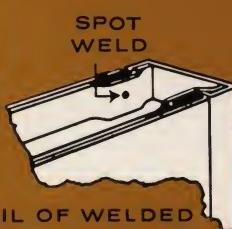
Precision-made doors and frames manufactured by mass production methods meet the stringent requirements of architects and contractors. Styled to please, designed to function smoothly and last for years, Amweld's Commodity Line is a practical and economical solution to the door problem in many types of buildings.

Door panels are made from prime quality roll-formed sheets which interlock with heavier gauge stiles. End closures are spot-welded in place to form a rigid door. Horizontal stiffeners reinforce front and back panels and provide extra structural rigidity.

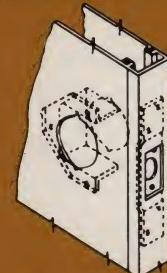
① INTERLOCKED STILE AND PANEL



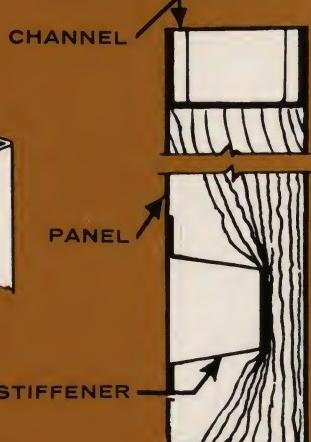
② DETAIL OF WELDED CORNER CONSTR. OF DOOR



③ DETAIL OF LOCK FRONT REINF. IN DOOR



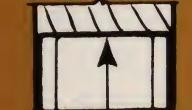
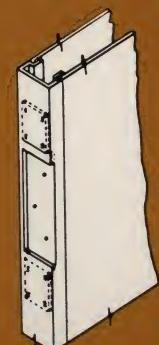
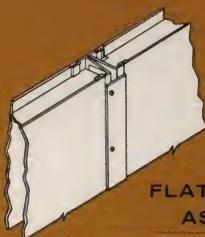
⑤ TYPICAL SECTION



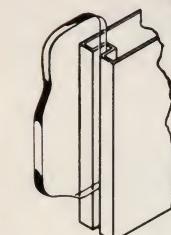
SOUND DEADENING INSULATION



FLAT SCREW-ON ASTRAGAL      DETAIL OF HINGE REINF. IN DOOR



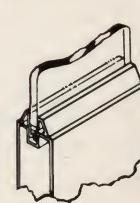
## 1 3/4" commodity line door glazing details



NEAT RIGID GLAZING GROOVE



FIELD-INSERTED MUNTIN BAR WITH SNAP-ON COVER



SNAP-IN GLAZING STRIPS

# series 100 Commodity Line door types and sizes

Figures in boxes below show square inches of free louver area.

| 1 3/8" flush panel |       | F | V | PL | TPL | DPL | VPL | G |
|--------------------|-------|---|---|----|-----|-----|-----|---|
| 1' 6"              |       |   |   |    |     |     |     |   |
| 2' 0"*             |       |   |   | 16 | 16  | 32  | 16  |   |
| 6' 8"              | 2' 4" |   |   | 32 | 32  | 64  | 32  |   |
| 2' 6"*             |       |   |   | 32 | 32  | 64  | 32  |   |
| 2' 8"*             |       |   |   | 32 | 32  | 64  | 32  |   |
| 3' 0"*             |       |   |   | 32 | 32  | 64  | 32  |   |
| 1' 6"              |       |   |   |    |     |     |     |   |
| 2' 0"*             |       |   |   | 16 | 16  | 32  | 16  |   |
| 7' 0"              | 2' 4" |   |   | 32 | 32  | 64  | 32  |   |
| 2' 6"*             |       |   |   | 32 | 32  | 64  | 32  |   |
| 2' 8"*             |       |   |   | 32 | 32  | 64  | 32  |   |
| 3' 0"*             |       |   |   | 32 | 32  | 64  | 32  |   |

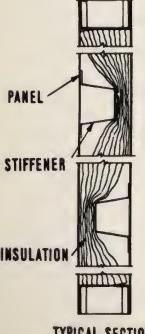
| 1 3/4" flush panel |              | F | V | PL | TPL | DPL | VPL | G |
|--------------------|--------------|---|---|----|-----|-----|-----|---|
| DOOR HEIGHT        | SINGLE WIDTH |   |   |    |     |     |     |   |
| 2' 0"*             |              |   |   | 16 | 16  | 32  | 16  |   |
| 2' 4"              |              |   |   | 32 | 32  | 64  | 32  |   |
| 6' 8"              | 2' 6"*       |   |   | 32 | 32  | 64  | 32  |   |
| 2' 8"*             |              |   |   | 32 | 32  | 64  | 32  |   |
| 3' 0"*             |              |   |   | 32 | 32  | 64  | 32  |   |
| 3' 4"*             |              |   |   | 32 | 32  | 64  | 32  |   |
| 3' 6"*             |              |   |   |    |     |     |     |   |
| 2' 0"*             |              |   |   | 16 | 16  | 32  | 16  |   |
| 2' 4"              |              |   |   | 32 | 32  | 64  | 32  |   |
| 7' 0"              | 2' 6"*       |   |   | 32 | 32  | 64  | 32  |   |
| 2' 8"*             |              |   |   | 32 | 32  | 64  | 32  |   |
| 3' 0"*             |              |   |   | 32 | 32  | 64  | 32  |   |
| 3' 4"*             |              |   |   | 32 | 32  | 64  | 32  |   |
| 3' 6"*             |              |   |   |    |     |     |     |   |

\*Inactive leaf available. Includes astragal and reinforcement for 6" surface bolts, furnished by others.

Also available as blank stile doors without astragals but reinforced for push plates or rim-type panic devices.

CHANNEL

Underwriters' Laboratories, Inc.  
INSPECTED



Commodity Line 1 3/4" flush and vision panel doors in 6' 8" and 7' 0" height can be supplied with Underwriters' Laboratories 1 1/2 hour B labels in all widths except 2' 0". 1 3/8" labeled doors available in 6' 8" height only—all widths.

The same sizes and types of doors can also be furnished with New York Board of Standards and Appeals 1 1/2-hr. label.

sizes available.

Types and sizes in shaded blocks are available for fast delivery. (1 3/4" doors are prepared for Series 161 locks only.)

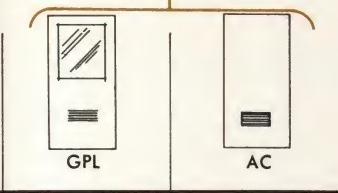
## door swing handing must be specified on Commodity Line

To determine the "hand" of a door, face the side which opens away from you and note location of hinges. If hinges are to your left, door is "left hand". If hinges are to your right, door is "right hand".



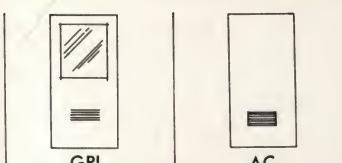


Figures in boxes below show square inches of free louver area.



|    |     |
|----|-----|
| 16 | 155 |
| 32 | 201 |
| 32 | 226 |
| 32 | 250 |
| 32 | 298 |

|    |     |
|----|-----|
| 16 | 155 |
| 32 | 201 |
| 32 | 226 |
| 32 | 250 |
| 32 | 298 |



|    |     |
|----|-----|
| 32 | 201 |
| 32 | 226 |
| 32 | 250 |
| 32 | 298 |
| 32 | 345 |

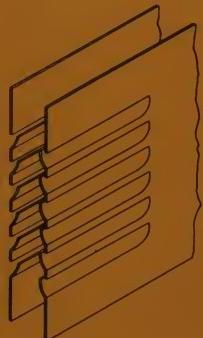
|    |     |
|----|-----|
| 32 | 201 |
| 32 | 226 |
| 32 | 250 |
| 32 | 298 |
| 32 | 345 |

AC grilles may be substituted for pierced louvers in all door types.

#### standard door glass sizes

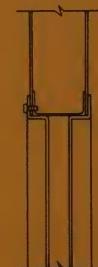
| DOOR HEIGHT | DOOR WIDTH | G                     | G2                                  | G3                                  | G4                                  |
|-------------|------------|-----------------------|-------------------------------------|-------------------------------------|-------------------------------------|
| 6' 8"       | 2' 4"      | 17 $\frac{1}{8}$ x 32 | 17 $\frac{1}{8}$ x 15 $\frac{1}{8}$ | 17 $\frac{1}{8}$ x 10 $\frac{1}{8}$ | 7 $\frac{1}{2}$ x 15 $\frac{1}{8}$  |
|             | 2' 6"      | 19 $\frac{1}{8}$ x 32 | 19 $\frac{1}{8}$ x 15 $\frac{1}{8}$ | 19 $\frac{1}{8}$ x 10 $\frac{1}{8}$ | 9 $\frac{1}{2}$ x 15 $\frac{1}{8}$  |
|             | 2' 8"      | 21 $\frac{1}{8}$ x 32 | 21 $\frac{1}{8}$ x 15 $\frac{1}{8}$ | 21 $\frac{1}{8}$ x 10 $\frac{1}{8}$ | 10 $\frac{1}{2}$ x 15 $\frac{1}{8}$ |
|             | 3' 0"      | 25 $\frac{1}{8}$ x 32 | 25 $\frac{1}{8}$ x 15 $\frac{1}{8}$ | 25 $\frac{1}{8}$ x 10 $\frac{1}{8}$ | 12 $\frac{1}{2}$ x 15 $\frac{1}{8}$ |
|             | 3' 4"      | 29 $\frac{1}{8}$ x 32 | 29 $\frac{1}{8}$ x 15 $\frac{1}{8}$ | 29 $\frac{1}{8}$ x 10 $\frac{1}{8}$ | 14 $\frac{1}{2}$ x 15 $\frac{1}{8}$ |
|             | 3' 6"      | 31 $\frac{1}{8}$ x 32 | 31 $\frac{1}{8}$ x 15 $\frac{1}{8}$ | 31 $\frac{1}{8}$ x 10 $\frac{1}{8}$ | 15 $\frac{1}{2}$ x 15 $\frac{1}{8}$ |
| 7' 0"       | 2' 6"      | 19 $\frac{1}{8}$ x 36 | 19 $\frac{1}{8}$ x 17 $\frac{1}{8}$ | 19 $\frac{1}{8}$ x 11 $\frac{1}{2}$ | 9 $\frac{1}{2}$ x 17 $\frac{1}{8}$  |
|             | 2' 8"      | 21 $\frac{1}{8}$ x 36 | 21 $\frac{1}{8}$ x 17 $\frac{1}{8}$ | 21 $\frac{1}{8}$ x 11 $\frac{1}{2}$ | 10 $\frac{1}{2}$ x 17 $\frac{1}{8}$ |
|             | 3' 0"      | 25 $\frac{1}{8}$ x 36 | 25 $\frac{1}{8}$ x 17 $\frac{1}{8}$ | 25 $\frac{1}{8}$ x 11 $\frac{1}{2}$ | 12 $\frac{1}{2}$ x 17 $\frac{1}{8}$ |
|             | 3' 4"      | 29 $\frac{1}{8}$ x 36 | 29 $\frac{1}{8}$ x 17 $\frac{1}{8}$ | 29 $\frac{1}{8}$ x 11 $\frac{1}{2}$ | 14 $\frac{1}{2}$ x 17 $\frac{1}{8}$ |
|             | 3' 6"      | 31 $\frac{1}{8}$ x 36 | 31 $\frac{1}{8}$ x 17 $\frac{1}{8}$ | 31 $\frac{1}{8}$ x 11 $\frac{1}{2}$ | 15 $\frac{1}{2}$ x 17 $\frac{1}{8}$ |
|             | 3' 8"      | 33 $\frac{1}{8}$ x 36 | 33 $\frac{1}{8}$ x 17 $\frac{1}{8}$ | 33 $\frac{1}{8}$ x 11 $\frac{1}{2}$ | 16 $\frac{1}{2}$ x 17 $\frac{1}{8}$ |
|             | 4' 0"      | 37 $\frac{1}{8}$ x 36 | 37 $\frac{1}{8}$ x 17 $\frac{1}{8}$ | 37 $\frac{1}{8}$ x 11 $\frac{1}{2}$ | 18 $\frac{1}{2}$ x 17 $\frac{1}{8}$ |

## details



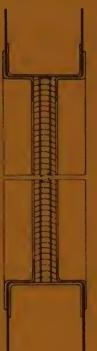
### louvers

Louvered doors have pierced louvers, with vanes stamped inward, leaving surface flush.



### 1 $\frac{1}{8}$ " door half glass and vision panels

Standard vision panel finished opening is 10" x 10". Glass 11" x 11", furnished by others. Secure side is on stop side of door.



### air conditioning grilles

Doors with air conditioning grilles have special insert grilles in following sizes.

| DOOR WIDTH | GRILLE SIZE | FREE AREA   |
|------------|-------------|-------------|
| 2' 4"      | 17" x 14"   | 201 sq. in. |
| 2' 6"      | 19" x 14"   | 226 sq. in. |
| 2' 8"      | 21" x 14"   | 250 sq. in. |
| 3' 0"      | 25" x 14"   | 298 sq. in. |
| 3' 4"      | 29" x 14"   | 345 sq. in. |

### 1 $\frac{1}{4}$ " door half glass

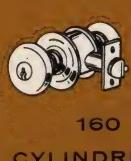
Half-glass doors have secure side on stop side of door. Glass furnished by others. Half-glass doors afford additional flexibility as they can be adapted to a variety of multi-light designs by means of field-applied muntin bars.

### standard lockset preparation permits choice of locks

Commodity Line 1 $\frac{1}{4}$ " doors can be prepared for locksets supplied by all major hardware manufacturers in accordance with Fed. Spec. FF-H-106A Series 86 (mortise), Series 161 (cylindrical), or Series 140 (integral), as shown. Commodity Line 1 $\frac{1}{8}$ " doors are prepared for locksets in accordance with Fed. Spec. FF-H-106A Series 160 (cylindrical 2 $\frac{1}{8}$  backset).



86  
MORTISE



160  
CYLINDRICAL



161  
CYLINDRICAL



140  
INTEGRAL

# Commodity Line

## architect's specifications

### Amweld® commodity line doors and frames.

#### general

Contractor shall furnish and install steel doors and frames as manufactured by Amweld Building Products, Niles, Ohio, a division of The American Welding & Manufacturing Co., Warren, Ohio, in all openings except as otherwise provided for in specifications.

#### 1½" doors (series 100)

**Construction**—Door stiles shall be formed of 18 gauge steel, and door panels shall be formed of 20 gauge steel interlocked with stiles and mechanically stiffened with 24 gauge stiffeners securely welded to the inner side of the panel. Stiles shall be provided with heavy gauge hardware reinforcements securely welded to their inside surfaces. Ends of the doors shall be closed and reinforced with channels securely spot welded to both panels and welded to panel and stile at their corners.

The interior of the door shall be provided with sound-deadening material, resistant to fire, vermin, moisture, mildew and rot. Door panels shall be prepared and reinforced for standard hardware, as specified in the hardware schedule.

#### 1¾" frames (series 200)

**Construction**—Frames shall be formed of 16 gauge steel and shall be furnished knocked-down for quick field assembly. Frames shall have heavy gauge reinforcing gussets at the corners and self-aligning tabs for secure locking of assembly. (Option: furnished completely assembled and welded at the corners.) Corners shall present neat, mitered joints. Hinge jambs shall be provided with heavy gauge steel hinge reinforcements welded in place, pierced and tapped for 1½ pr. 4½" x 4½" template hinges and protected with welded-steel plaster guards. Hinges furnished by others. Strike jambs shall be provided with strike cut-out for strike plates of locksets in accordance with Fed. Spec. FF-H-106a Series 86 (mortise), Series 161 (cylindrical), Series 140 (integral), or the "Universal Strike." The welded-in steel strike reinforcement will be pierced and tapped for specified strike-plate. Strike cut-out shall be covered with integral plaster-guard. Strike jambs shall have rubber bumper mutes furnished for stops. Three steel anchors shall be provided for each jamb, and shall be stud, masonry or plaster type, as specified.

#### lockset preparation (1¾")

Doors and frames shall be prepared to take locksets manufactured under Federal Specifications FF-H-106a, series 161 (cylindrical), 86 (mortise), or 140 (integral), and shall accommodate standard locksets manufactured in accordance with these specifications. Holes for mounting surface-applied escutcheons to be drilled in the field by others. Lock preparations shall be on center line of door (except 7' 0" doors), enabling flush doors to be used as either right or left-hand doors by inverting. Hinge reinforcements shall be drilled and tapped for standard 4½" x 4½" template hinges, not furnished. Lock reinforcements shall be drilled and tapped.

The inactive door in pairs of doors shall be reinforced for a 6" top and bottom surface bolt, not furnished but shall include an astragal. Inactive doors for push plates or rim type panic devices shall have blank stiles and no astragal.

(Specifications subject to change without notice.)

#### 1¾" frames (series 200)

**Construction**—Frames shall be formed of 18 gauge steel. Frames to be furnished as Amweld Inter-Lok Frames for 1¾" doors, supplied with loose headers equipped at each mitered joint with heavy gauge channel-shaped reinforcements. Jambs and header to be equipped with tabs and slots for locking assembly. (Option—May be furnished as a complete 1-piece, welded assembly with header and jambs securely welded.) The strike cut-out shall be provided with heavy gauge steel reinforcement securely spot welded in the jamb and covered with a plaster guard. Steel anchors shall be provided for solid bonding of the frame to the wall. Hinge jambs shall be provided with two 3½" x 3½" 3-knuckle hinge leaves welded in place. Primed 2-knuckle leaves of hinges and hinge pins to be furnished. (Option—May be furnished with welded reinforcement, pierced and tapped for two 3½" x 3½" template or non-template hinges, not furnished.)

#### 1¾" doors (series 100)

**Construction**—Door stiles shall be formed of 18 gauge steel, and door panels shall be formed of 20 gauge steel, interlocked with stiles and mechanically stiffened with 24 gauge stiffeners securely welded to the inner side of the panel. Stiles shall be provided with heavy gauge hardware reinforcements securely welded to their inside surfaces. Ends of the doors shall be closed and reinforced with die-formed channels securely spot welded to both panels and welded to panel and stile at their corners.

The interior of the door shall be provided with sound-deadening material, resistant to fire, vermin, moisture, mildew and rot. Door panels shall be prepared and reinforced for standard hardware, as specified in the hardware schedule.

#### lockset preparation (1¾")

Doors and frames shall be prepared to take locksets manufactured under Federal Specifications FF-H-106a, and shall accommodate standard locksets manufactured in accordance with specifications, series 160 (cylindrical)—2¾" backset. Lock preparation shall be on center line of door, (except 7' 0" size), enabling flush doors to be used as either right or left hand by inverting.

#### identification label

| AMWELD BUILDING PRODUCTS<br>Niles, Ohio |      |       |       |      |           |              |
|---|------|-------|-------|------|-----------|--------------|
| SERIES                                  | TYPE | STYLE | DEPTH | HAND | CLOSER    | SPEC. NUMBER |
| 2                                       | WGS  | 5     | 3068  | R    | D3 S CLBS | 0-0000       |

A DIVISION OF THE AMERICAN WELDING & MFG. CO.

This identification label is applied to all frames, frame parts, and door cartons. It indicates all

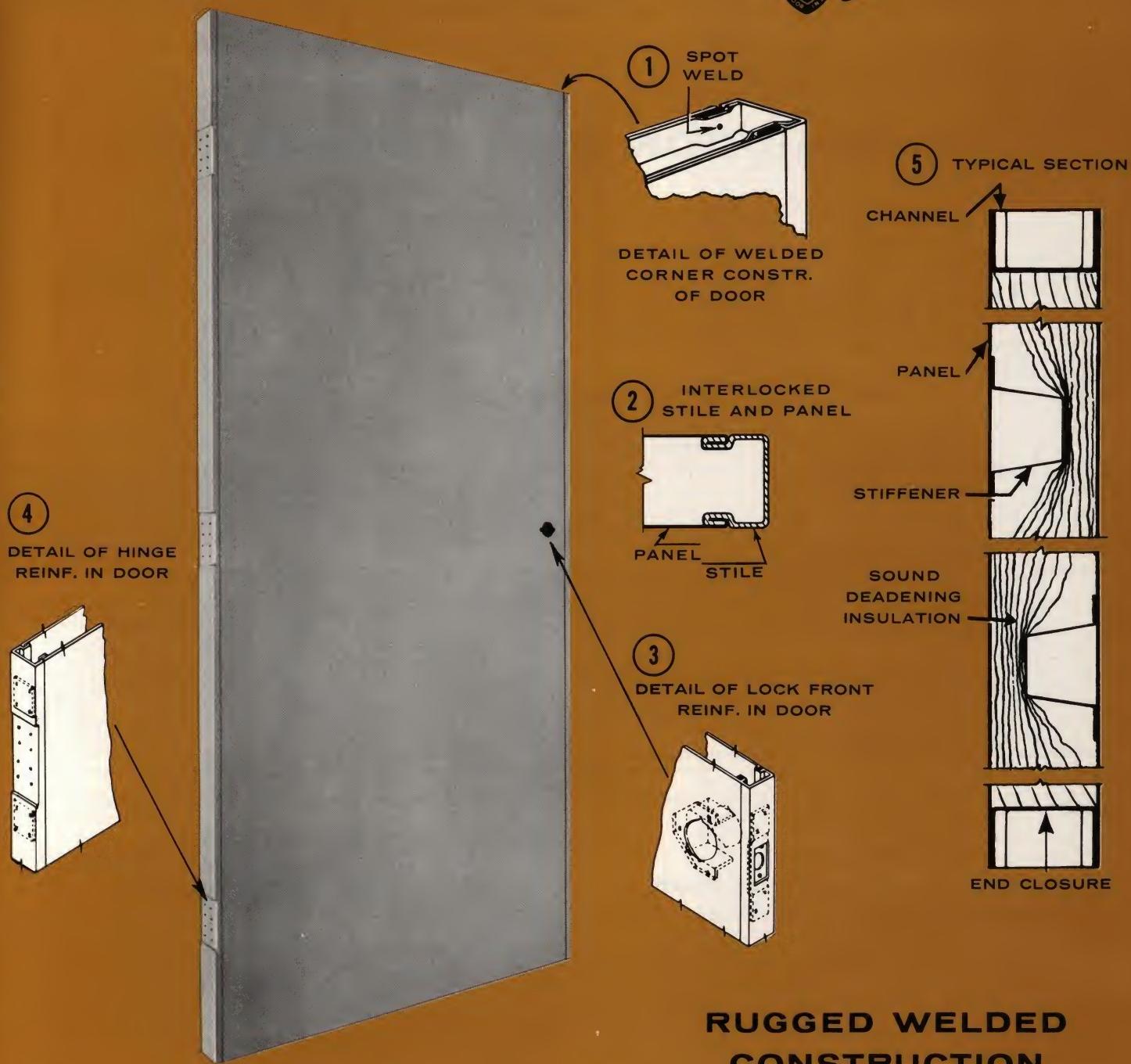
facts, such as size, style, and special preparation, as well as architect and job mark number. The label is placed (a) on the floor anchor of jambs and frames, (b) inside the throat of loose headers, and (c) two places on the edge of door cartons. This placement permits distributors to determine stock without removing jambs and headers from shelves and doors from cartons. Contractors are able to properly locate doors and frames at the job site. Doors and frames can be installed and painted without removing labels.

# series 700 STURDI-DOORS



**AMWELD**

16b  
Amw



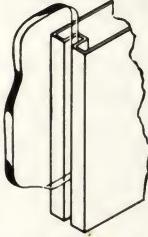
## RUGGED WELDED CONSTRUCTION

Sturdi-Door is a ruggedly built door with an economy size price tag. Perfectly suited for those applications where the punishment of high frequency use calls for a door of sturdy construction but where price is critical.

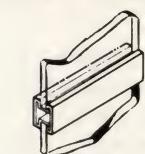
Careful design and modern mass production techniques have combined to produce this top dollar value in 1 $\frac{3}{4}$ " flush panel doors.

Door panels are made from prime quality 18 gauge roll-formed sheets. Interlocking stiles are of 16 gauge steel. End closures are spot welded in place to form a rigid panel assembly. Horizontal stiffeners reinforce front and back panels and provide extra structural rigidity.

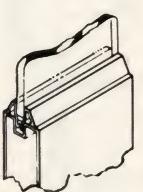
### glazing details



NEAT RIGID GLAZING GROOVE



FIELD-INSERTED MUNTIN BAR WITH SNAP-ON COVER



SNAP-IN GLAZING STRIPS

# series 700 STURDI-DOOR line

STURDI-DOORS are flush panel design, suitable for schools, offices, factories and commercial buildings. They present a neat, trim appearance, and are designed and constructed for long, maintenance-free service.

## STURDI-DOOR types and sizes

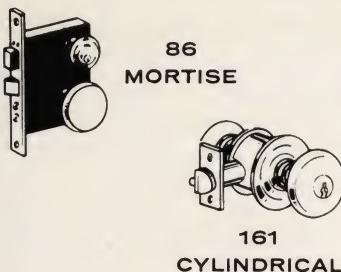
| 1¾" flush panel |              | F | V | L | TL | DL | VL | G |
|-----------------|--------------|---|---|---|----|----|----|---|
| DOOR HEIGHT     | SINGLE WIDTH |   |   |   |    |    |    |   |
| 2' 0"*          |              |   |   |   |    |    |    |   |
| 2' 4"           |              |   |   |   |    |    |    |   |
| 2' 6"*          |              |   |   |   |    |    |    |   |
| 6' 8"           |              |   |   |   |    |    |    |   |
| 2' 8"*          |              |   |   |   |    |    |    |   |
| 3' 0"*          |              |   |   |   |    |    |    |   |
| 3' 4"*          |              |   |   |   |    |    |    |   |
| 3' 6"*          |              |   |   |   |    |    |    |   |
| 2' 0"*          |              |   |   |   |    |    |    |   |
| 2' 4"           |              |   |   |   |    |    |    |   |
| 2' 6"*          |              |   |   |   |    |    |    |   |
| 7' 0"           |              |   |   |   |    |    |    |   |
| 2' 8"*          |              |   |   |   |    |    |    |   |
| 3' 0"*          |              |   |   |   |    |    |    |   |
| 3' 4"*          |              |   |   |   |    |    |    |   |
| 3' 6"*          |              |   |   |   |    |    |    |   |

\*Inactive leaf available. Includes astragal and reinforcement for 6" surface bolts, furnished by others.

Also available as blank stile doors without astragals but reinforced for push plates or rim-type panic devices.

### standard lockset preparation permits choice of locks

STURDI-DOOR LINE 1¾" doors can be prepared for locksets supplied by all major hardware manufacturers in accordance with Fed. Spec. FF-H-106A Series 86 (mortise), Series 161 (cylindrical), or Series 140 (integral), as shown.



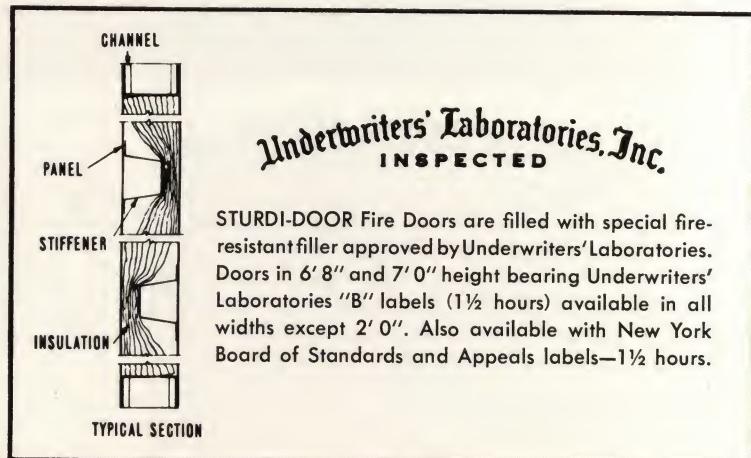
### door swing

The STURDI-DOOR is universally handed. Doors may be adapted for either right or left hand swing by reversing hinges. Openings in hinge stile mortise are then concealed by means of special hinge fillers.

### miscellaneous hardware

The top of the STURDI-DOOR is reinforced internally for the mounting of closers and other surface applied hardware. Blank stile doors are internally reinforced for push plates or rim type panic devices.

**Underwriters' Laboratories, Inc.  
INSPECTED**



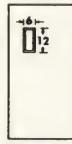
STURDI-DOOR Fire Doors are filled with special fire-resistant filler approved by Underwriters' Laboratories. Doors in 6' 8" and 7' 0" height bearing Underwriters' Laboratories "B" labels (1½ hours) available in all widths except 2' 0". Also available with New York Board of Standards and Appeals labels—1½ hours.

# choice of 12 functional door designs

Flush door types include louvered, vision-light and half-glass, as well as combinations of these, for a total of 12 styles—in standard heights and widths. Half-glass doors afford additional flexibility, as they can be adapted to a variety of multi-light designs by means of field-applied muntin bars.



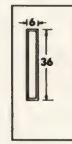
GL



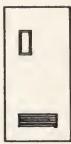
VV1



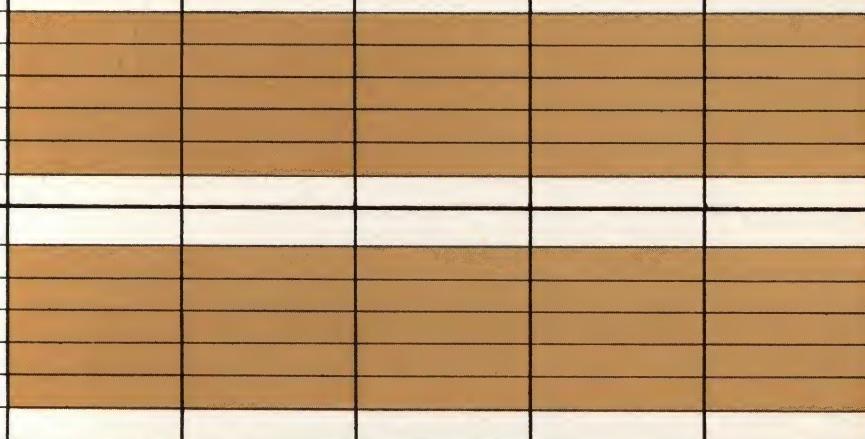
VV2



VV3



VVL



sizes available.

Types and sizes in shaded blocks are available for fast delivery on 1 1/4" doors prepared for Series 161 locks only.

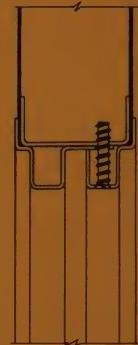
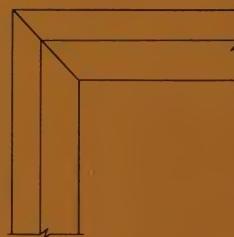
**TOP and BOTTOM CAPS** available where doors are to be used with vinyl insert type thresholds and weather-stripping at top. We suggest completely grouting the top cap on all exterior applications to prevent moisture entering top of door.

| DOOR WIDTH | LOUVER SIZE | FREE AREA*  |
|------------|-------------|-------------|
| 2' 0"      | 13" x 14"   | 146 sq. in. |
| 2' 4"      | 17" x 14"   | 190 sq. in. |
| 2' 6"      | 19" x 14"   | 213 sq. in. |
| 2' 8"      | 21" x 14"   | 235 sq. in. |
| 3' 0"      | 25" x 14"   | 280 sq. in. |
| 3' 4"      | 29" x 14"   | 325 sq. in. |
| 3' 6"      | 31" x 14"   | 347 sq. in. |
| 3' 8"      | 33" x 14"   | 370 sq. in. |
| 4' 0"      | 37" x 14"   | 414 sq. in. |

\*Free Area shown is based on the standard "inverted V" blade louver. The free area will vary with the substitution of other types of louvers.



## details



### vision panels

Standard vision panel finished opening is 10" x 10". Glass 11" x 11", furnished by others. Secure side determined in the field.

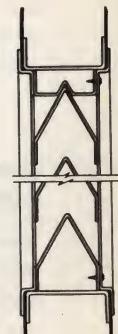


### half glass

Snap-in glazing strip design permits job-site selection of secure side. Formed strips have a neat, trim appearance, with no screws. Glazing furnished by others.

### inverted V-blade louver

In addition to the standard louver shown here, the Sturdy-Door may also be furnished with "inverted Y," "Z blade," and "lightproof" louvers. Also available are adjustable louvers with either manual or "automatic fuse link" mechanisms. Louvers can also be furnished with screens of various materials and gauges.





## STURDI-DOOR architect's specifications

### general

Contractor shall furnish and install steel doors and frames as manufactured by Amweld Building Products, Niles, Ohio, a division of The American Welding & Manufacturing Co., Warren, Ohio, in all openings except as otherwise provided for in specifications.

### 1 1/4" doors (series 700)

**Construction**—Door stiles shall be formed of 16 gauge steel, and door panels shall be formed of 18 gauge steel interlocked with stiles and mechanically stiffened with 24 gauge stiffeners securely welded to the inner side of the panel. Stiles shall be provided with heavy gauge hardware reinforcements securely welded to their inside surfaces. Ends of the doors shall be closed and reinforced with channels securely spot welded to both panels and welded to panel and stile at their corners.

The interior of the door shall be provided with sound-deadening material, resistant to fire, vermin, moisture, mildew and rot. Door panels shall be prepared and reinforced for standard hardware, as specified in the hardware schedule.

**glazing**—Doors of half-glass shall be furnished with formed steel glazing strips of the snap-in type, to permit selection of secure side in the field. Muntin bars for multi-light glazing shall be of field-applied type. Glazing arrangement shall accommodate 1/4" thick glass, supplied by others. Vision-light doors shall provide for field installation of glass panels. Center line of standard vision light is located 5' 3" from bottom of door, with net opening of 10" x 10". Top of vertical vision lights shall be located 5' 6" from bottom of door. Net area of 72 sq. in. (6" x 12" light), 144 sq. in. (6" x 24" light), and 216 sq. in. (6" x 36" light).

**hardware**—Lockset preparation shall provide for field installation of locksets manufactured in accordance with Fed. Spec. FF-H-106A Series 86 (mortise), Series 161 (cylindrical) or Series 140 (integral), with flat fronts. Lock cut-outs shall be reinforced with heavy gauge steel and pierced and tapped for mounting specified locksets. Mounting holes for surface applied escutcheons shall be drilled in the field by others.

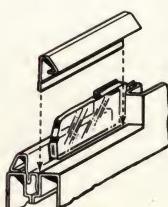
### rust-inhibitive finish

All exposed surfaces of doors are first chemically cleaned, then factory painted, under controlled conditions, with baked-on zinc chromate primer, for maximum resistance to rust and corrosion. We recommend finish painting with oil base, spirit-thinned, semi-gloss enamel.



### glazing simple and quick with snap-in molding

Snap-in glazing strip design permits job-site selection of secure side. Formed strips have a neat, trim appearance, with no screws. Glazing furnished by others.



Hinge-mortises shall be reinforced with heavy gauge steel plates, welded in place and pierced and tapped for 1 1/2 pair 4 1/2" x 4 1/2" template hinges. Hinges furnished by others.

Mortises shall extend full width of hinge-stile, and filler-plates shall be provided to permit installation of hinges for right-hand or left-hand swing, as specified.

**miscellaneous hardware**—Where called for on drawings or otherwise specified, panic hardware, closers, or other surface-mounted hardware shall be provided with reinforcement for drilling and tapping in the field.

Inactive-leaf doors, where called for on drawings or in door schedule, shall be reinforced for top and bottom surface mounted bolts. Strike stile shall be provided with screwed-on astragal. Inactive doors for push plates or rim type panic devices shall have blank panels and be furnished without astragals.

**louvers**—Louvers for Sturdi-Doors shall be of insert type with inverted V baffles.

**finish**—Exposed surfaces on doors shall be chemically cleaned and given one baked, shop coat of zinc chromate primer.

### identification label

| AMWELD BUILDING PRODUCTS<br>Niles, Ohio |      |       |       |      |        |                         |
|---|------|-------|-------|------|--------|-------------------------|
| SERIES                                  | TYPE | STYLE | DEPTH | HAND | CLOSER | SPEC. PREP. A.W. NUMBER |
| 2                                       | WGS  | 5     | R     | CLBS |        | 0-0000                  |
| 4                                       |      | 3068  | D3 S  |      | 8      | G.A. MARK               |

A DIVISION OF THE AMERICAN WELDING & MFG. CO.

This identification label is applied to all frames, frame parts, and door cartons. It indicates all

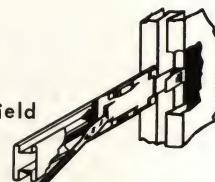
facts, such as size, style, and special preparation, as well as architect and job mark number. The label is placed (a) on the floor anchor of jambs and frames, (b) inside the throat of loose headers, and (c) two places on the edge of door cartons. This placement permits distributors to determine stock without removing jambs and headers from shelves and doors from cartons. Contractors are able to properly locate doors and frames at the job site. Doors and frames can be installed and painted without removing labels.

### "K-D" Inter-lok frames for STURDI-DOORS

STURDI-DOORS are designed for use with Commercial and Commodity Line 1 1/4" K-D Inter-Lok Frames. They are formed from 16 gauge steel. Frames are furnished knocked-down for easy handling and economical shipping. Easy to erect—take only minutes to install in stud or masonry walls. Corners are mitered, presenting neat joints. Available in single or double widths. On special order, frames may be furnished assembled with corners welded. See details starting page 2 and 14.

### field-applied muntin bars for multi-light flexibility

Muntin bars furnished "k-d", permit field adaptation of any half-glass door to multi-light designs. 6' 8" and 7' 0" doors are convertible to 2, 3, 4, or 6 lights.



# Commercial Line heavy-duty doors & frames for school, institutional and commercial buildings

A rugged rail and stile door for high frequency service. Produced on precision-tooled assembly lines, Amweld Commercial Line doors and frames offer clean contemporary styling, quiet operation and exceptional structural strength. Unique design features also make possible new savings in installation costs.

Doors are of either flush panel or recessed panel types, 1 $\frac{3}{4}$ " thick. Rails and stiles are of 16 gauge steel, and form a continuous tubular frame with mitered corners reinforced, face welded and ground smooth. Flush-style panels are formed of two sheets of 18 gauge steel connected by interior stiffeners, and are effectively sound deadened. Recessed-style panels are formed of double sheets of 18 gauge steel, separated by a resilient spacer. Panels inter-lock with rails and stiles to form a totally integrated rigid structure. Doors operate smoothly and quietly for long, maintenance-free life.

## select from 27 functional door designs

Door types include flush, recessed panel, louvered, vision-light, half glass and full glass, as well as combinations of these, for a total of 27 styles—in standard heights and widths. Half glass doors afford additional flexibility, as they can be adapted to a variety of multi-light designs by means of field-applied muntin bars. Any door may be field-adapted for either right hand or left hand swing, as required. Doors to be used in pairs also are available, including inactive-leaf type.

## "k-d" Inter-Lok frames fit variety of wall conditions

Commercial Line frames are formed of 16 gauge or 14 gauge steel, and feature a full 2" face. Frames are furnished knocked down, with self-aligning Inter-Lok corners, for quick field assembly. On special order, frames may be furnished fully assembled and welded. Corners show neat mitered joints. Unique system of interchangeable anchors permits field adaptation of any frame for either stud or masonry walls, as required. Floor anchors are adjustable. Available in single and double widths.

### phosphatized finish



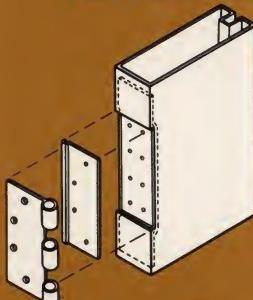
All exposed surfaces of both doors and frames are first chemically cleaned, then coated with a heavy phosphate deposit, chemically bonded to the surface. Factory painted under controlled conditions with baked-on zinc chromate primer, for maximum resistance to rust and corrosion.

We recommend finishing with oil base, spirit-thinned semi gloss enamel.

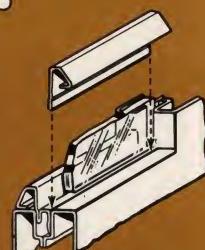
### VERSATILITY

#### universal handing

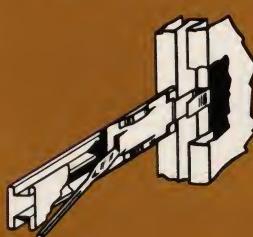
Doors may be adapted for either right-hand or left-hand swing by reversing hinges. Openings in hinge-stile mortise are then concealed by means of special hinge-filters. Strike stile has slightly rounded edge, enabling door to clear frame either way.



#### glazing simple and quick with snap-in molding



Snap-in glazing strip design permits job-site selection of secure side. Formed strips have a neat, trim appearance, with no screws. Glazing furnished by others.



#### field-applied muntin bars for multi-light flexibility

Muntin bars furnished "k-d", permit field adaptation of any half glass door to multi-light designs. 6' 8" and 7' 0" doors are convertible to 2, 3, or 4 lights.

### standard lockset preparation permits choice of hardware

Commercial Line Doors can be prepared for locksets supplied by all major hardware manufacturers in accordance with Fed. Spec. FF-4-106A, Series 86 (mortise), Series 161 (cylindrical), or Series 140 (integral), as shown. (All locksets must have flat fronts.) Thus, with Amweld Commercial Line Doors, selection is not confined to locksets of any one manufacturer or one type. Both doors and frames are factory reinforced, mortised, pierced and tapped for 1 $\frac{1}{2}$  pair of 4 $\frac{1}{2}$ " x 4 $\frac{1}{2}$ " template hinges (not furnished).



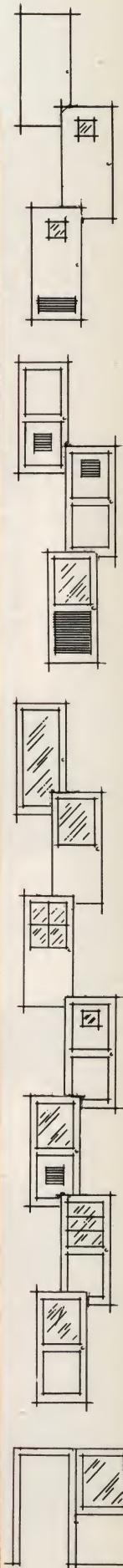
161  
CYLINDRICAL



140  
INTEGRAL



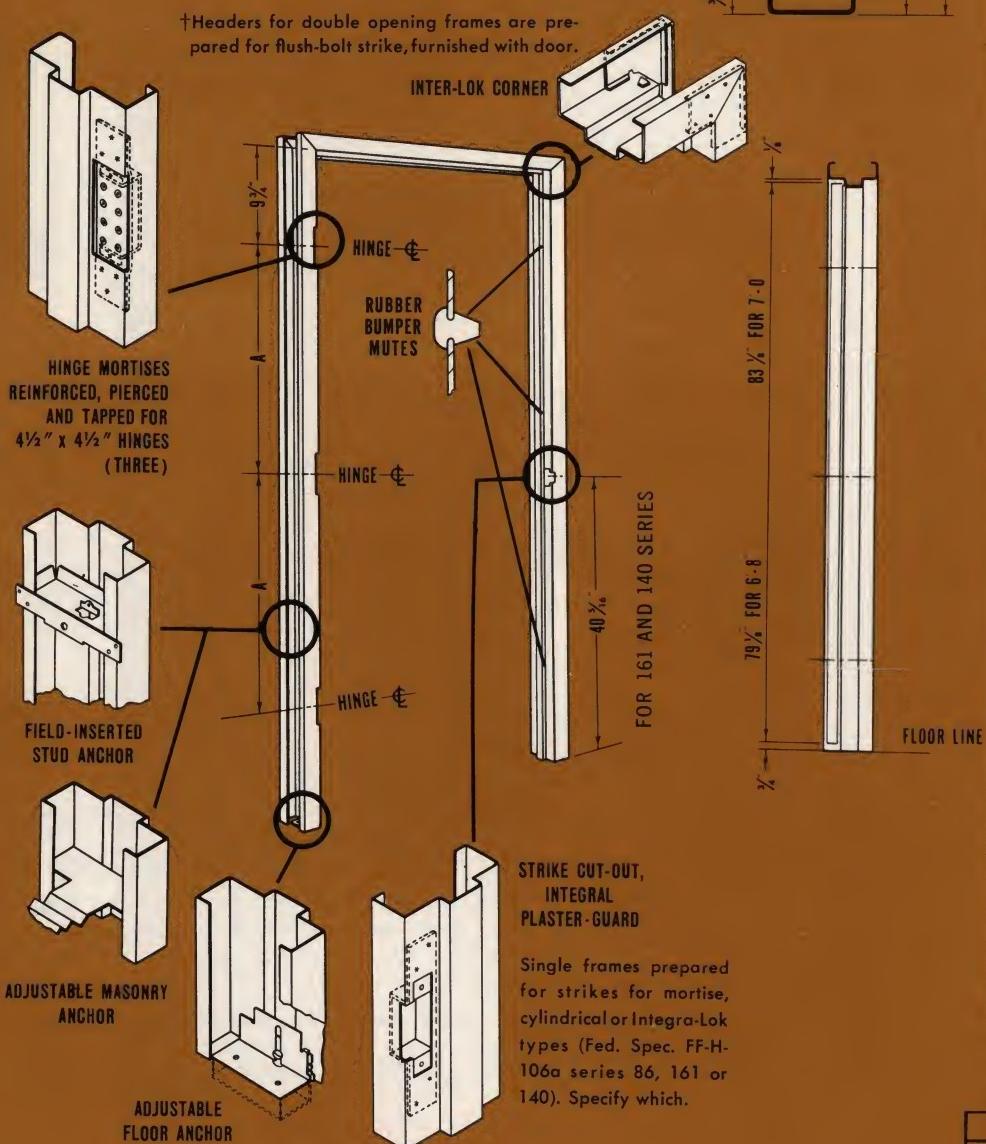
86  
MORTISE



# series 400 Commercial Line "K-D" inter-lok frames

Specifically made for heavy duty, Amweld Commercial Line steel frames feature a full 2" face. Formed from 16 gauge or 14 gauge steel, as specified, frames have 5½" jamb depth, and can be adapted at the job-site for use in masonry or wood stud partitions simply by applying the correct anchor. Both wood-stud and masonry anchors are removable snap-in type. Adjustable floor anchors compensate for sub-floor installations. Shipped knocked-down, frames are quickly assembled by one man using only a hammer. Self-aligning Inter-Lok mitered corners assure stability and dimensional accuracy. Hinge mortises are reinforced, pierced and tapped for 1½ pair 4½" x 4½" template hinges, not furnished. Heavily phosphatized and coated with baked-on, rust inhibitive primer. Available in sizes corresponding to Commercial Line doors, including double widths. In ordering, specify active hand.

†Headers for double opening frames are prepared for flush-bolt strike, furnished with door.



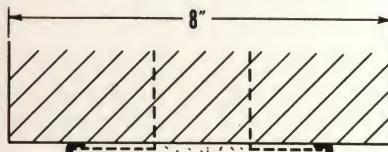
"A" Dimension = Spacing of Hinges

| Ht.   | Hinges | Size            | Spacing   |
|-------|--------|-----------------|-----------|
| 6' 8" | 3      | 4 1/2" x 4 1/2" | 29 15/16" |
| 7' 0" | 3      | 4 1/2" x 4 1/2" | 31 15/16" |

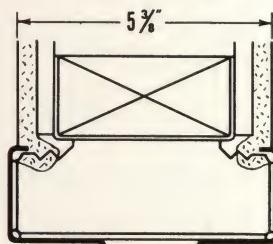
CEILING STRUTS  
ARE AVAILABLE  
FOR INSTALLATION  
IN PLASTER WALLS—  
ON SPECIAL ORDER.

## installation details

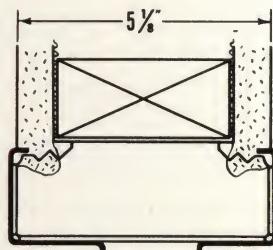
### details (3"=1')



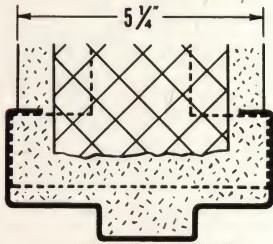
—BRICK, OR  
CONCRETE BLOCK WALL



—2x4 STUD, ROCK LATH  
AND PLASTER



—2x4 STUD, METAL LATH  
AND PLASTER



—4" HOLLOW TILE OR  
PYROBAR® PLASTERED

| frame sizes |        |        |        |
|-------------|--------|--------|--------|
| single      | double | single | double |
| 6' 8"       | 7' 0"  | 6' 8"  | 7' 0"  |
| 2' 0"       | 2' 0"  | 4' 0"  | 4' 0"  |
| 2' 4"       | 2' 4"  | 5' 0"  | 5' 0"  |
| 2' 6"       | 2' 6"  | 5' 4"  | 5' 4"  |
| 2' 8"       | 2' 8"  | 6' 0"  | 6' 0"  |
| 3' 0"       | 3' 0"  | 6' 8"  | 6' 8"  |
| 3' 4"       | 3' 4"  | 7' 0"  | 7' 0"  |
| 3' 6"       | 3' 6"  | 7' 4"  | 8' 0"  |
| 3' 8"       |        |        |        |
| 4' 0"       |        |        |        |

# series 400 Commercial Line transoms, side lights and borrowed lights

Amweld Commercial Line transoms, side lights and borrowed lights can be installed singly, or as component parts in combination of all three—which can be put together in the field. By means of simple mullioning splines, supplied by Amweld, transoms and frames can be joined with matching side lights, borrowed lights or any combination of both—in any length. Entire partitions extending for the full length of a building can be assembled and erected by a few men, using various arrangements of these units. Glaze molding, furnished with each unit, is trim in appearance, close-fitting and easy to insert, showing no screws.

Transoms, side lights and borrowed lights with visible miter are made of prime 14 gauge steel, and are securely reinforced and welded at all joints. Exposed faces are 2" wide. Frames can be equipped in the field with anchors for wood-stud or masonry. Floor anchors are adjustable. Where more than two side lights are to be joined together, making an inaccessible mullion, special U-section floor anchors can be provided.

## sizes

### Transom and Borrowed Light Units

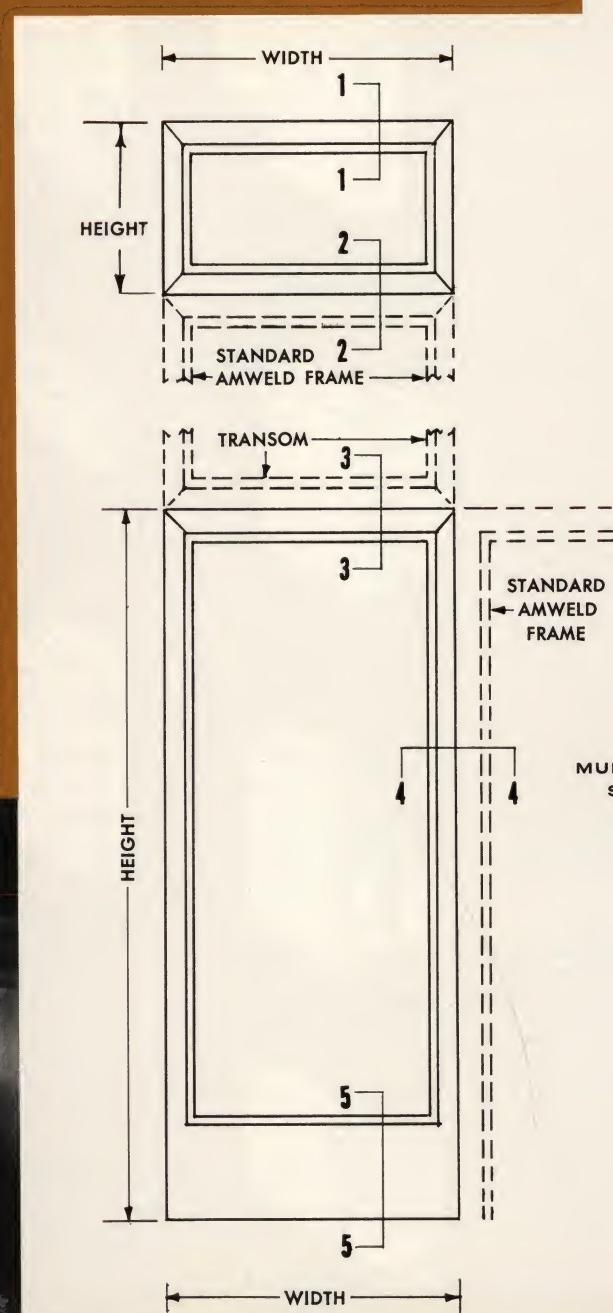
HEIGHTS—Available 1' 0" minimum to 4' 0" maximum.

WIDTHS—Equal to Standard Series 400 Frames both double and single widths.

### Sidelights

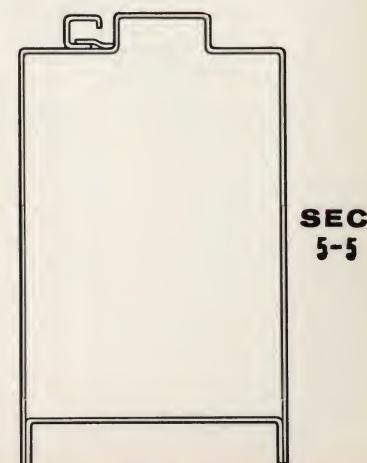
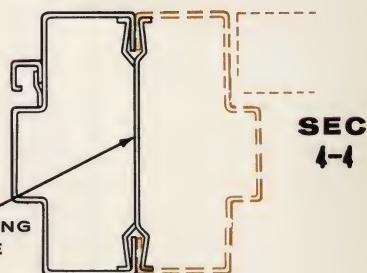
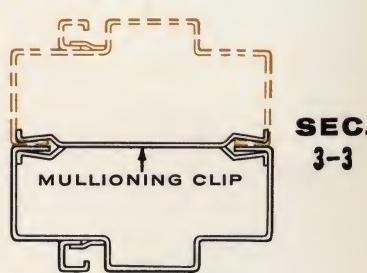
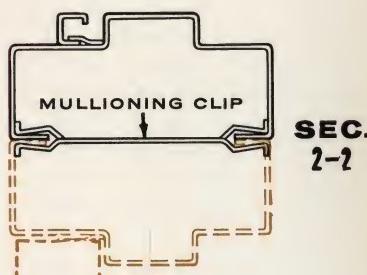
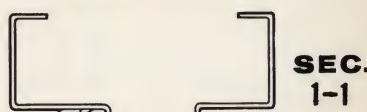
HEIGHTS—Available in 6' 8" and 7' 0".

WIDTHS—From 1' 0" minimum to 4' 0" maximum.



## installation details

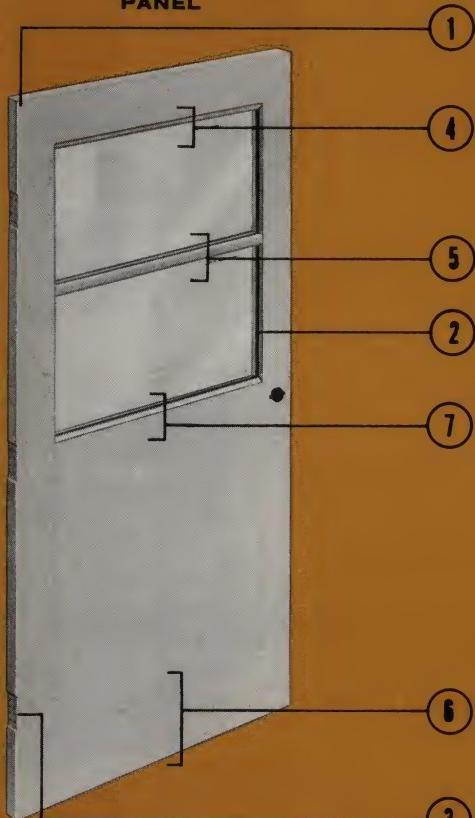
scale (3" = 1')



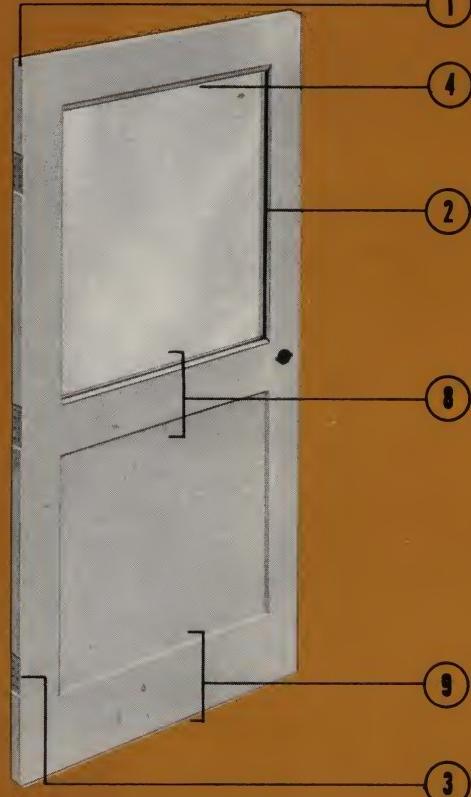
# series 300 Commercial Line doors



FLUSH  
PANEL

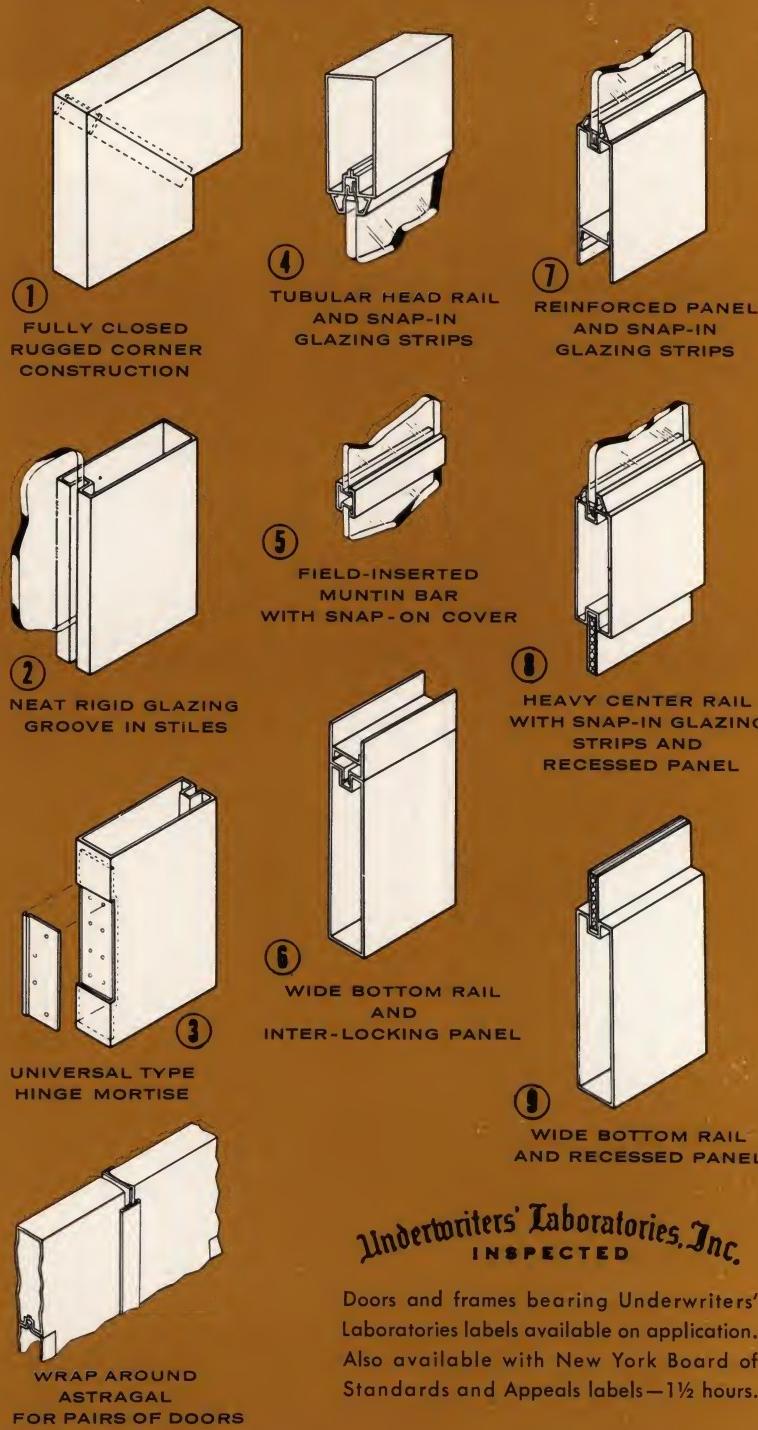


RECESSED  
PANEL



## doors designed for hard service

Sound engineering, precision workmanship, quality materials—plus many years of experience in the metalworking field—these are some of the ingredients that go into every door and frame that comes off the production line at Amweld. As shown in the drawings below, these rugged rail-and-stile doors are so integrated that the wear and tear of daily use is absorbed throughout their structure. Strength, rigidity and permanence are implicit in all details. The end result is lasting, trouble-free operation—handsome appearance—ease of installation—and the kind of toughness needed in today's and tomorrow's buildings.



Underwriters' Laboratories, Inc.  
INSPECTED

Doors and frames bearing Underwriters' Laboratories labels available on application. Also available with New York Board of Standards and Appeals labels—1½ hours.



# Commercial Line architect's specifications

## general

Contractor shall furnish and install steel doors and frames as manufactured by Amweld Building Products, Niles, Ohio, a division of American Welding & Manufacturing Co., Warren, Ohio, in all openings except as otherwise provided for in specifications.

## frames (series 400)

**construction**—Frames shall be formed of (select one) 16 gauge/14 gauge steel in double rabbeted design, having 2" exposed faces and 5½" depth. Frames shall be furnished knocked-down, and designed for quick field assembly with heavy gauge channel-shaped steel gussets at the corners and self-aligning tabs for secure locking of assembly. (Option: furnished completely assembled and welded at the corners.) Corners shall present visible mitered joints. Hinge jambs shall be provided with heavy gauge steel hinge reinforcements welded in place, pierced and tapped for 1½ pair 4½" x 4½" template hinges and protected with welded-steel plaster guards. Hinges furnished by others.

Strike jambs shall be provided with strike cut-out for strike plates of locksets in accordance with Federal Spec. FF-H-106A Series 86 (mortise type), Series 161 (cylindrical type), Series 140 (integral type), or the "Universal Strike." The welded-in steel strike reinforcement will be pierced and tapped for the specified strike plate. Strike cut-out shall be covered with integral plaster-guard. Strike jambs shall have three rubber bumper mutes furnished for stops. Three steel anchors shall be provided for each jamb, and shall be stud or masonry type as specified. Anchors shall be insertable in the field. Floor anchors shall be vertically adjustable.

## doors (series 300)

**materials and construction**—Doors shall be of rigid rail-and-stile construction in (select one) flush panel/recessed panel design. Stiles and rails shall be of 16 gauge steel mitered at the corners, reinforced with channels, face-welded and ground smooth. Panels shall be of flat 18 gauge steel, separated with inter-locking stiffeners on approximately 12" centers (recessed panels separated with resilient spacing material), and internally coated with standard sound-deadening material.

**glazing**—Doors of half glass or full glass types shall be furnished with formed steel glazing strips of the snap-in type, to permit selection of secure side in the field. Muntin bars for multi-light glazing shall be of field-applied type. Glazing arrangement shall accommodate ¼" thick glass, supplied by others. Vision-light doors shall provide for field installation of glass panels with center line of vision located 5' 3" from bottom of door, with net opening of 10" x 10".

**hardware**—Lockset preparation shall provide for field installation of locksets manufactured in accordance with Fed. Spec. FF-H-106A Series 86 (mortise), Series 161 (cylindrical)

or Series 140 (integral), with flat fronts. Lock cut-outs shall be reinforced with heavy gauge steel and pierced and tapped for mounting specified locksets. Mounting holes for surface applied escutcheons shall be drilled in the field by others.

Hinge-mortises shall be reinforced with heavy gauge steel plates, welded in place and pierced and tapped for 1½ pair 4½" x 4½" template hinges. Hinges furnished by others.

Mortises shall extend full width of hinge-stile, and filler-plates shall be provided to permit installation of hinges for right-hand or left-hand swing, as specified.

**miscellaneous hardware**—Where called for on drawings or otherwise specified, panic hardware, closers, or other surface-mounted hardware shall be field installed by use of Banc-Lock expansion nuts of correct size, inserted in holes spaced by template of the accessory and drilled by the contractor.

Inactive-leaf doors, where called for on drawings or in door schedule, shall be furnished with top and bottom flush bolts to mount in edge of stile and provided with strike plate for frame header. Strike stile shall be provided with welded-on wrap-around astragal. Inactive doors for push plates or rim type panic devices shall have blank stiles and be furnished without astragals.

**louvers**—Louvers for flush panel doors shall be of insert type with inverted V baffles, and shall occupy space between stiles and 14½" above bottom rail. (On flush-panel half-glass doors, louver shall fill entire lower panel space—28".) Louvers for recessed panel doors shall be of the fixed type, stamped into panels in accordance with design illustrated in current manufacturer's catalog.

**finish**—Exposed surfaces on both doors and frames shall be phosphatized and given one baked, shop coat of zinc chromate primer.

## identification label

| AMWELD |      | BUILDING PRODUCTS |       |        | Niles, Ohio |          |
|--------|------|-------------------|-------|--------|-------------|----------|
| SERIES | TYPE | STYLE             | DEPTH | HAND   | CLOSER      | SPEC.    |
|        |      |                   |       |        | PREP.       | NUMBER   |
| 2      | WGS  | 3068              | 5     | R      | CLBS        | 0-0000   |
| 4      |      | WIDTH             | D3    | S      | 8           |          |
|        |      | HEIGHT            | LOCK  | ANCHOR | BOLT        | GA. MARK |
|        |      |                   | HINGE |        | PREP.       |          |

A DIVISION OF THE AMERICAN WELDING & MFG. CO.

This identification label is applied to all frames, frame parts, and door cartons.

It indicates all facts, such as size, style, and special preparation, as well as architect and job mark number. The label is placed (a) on the floor anchor of jambs and frames, (b) inside the throat of loose headers, and (c) two places on the edge of door cartons. This placement permits distributors to determine stock without removing jambs and headers from shelves and doors from cartons. Contractors are able to properly locate doors and frames at the job site. Doors and frames can be installed and painted without removing labels.



# series 300 Commercial Line

## door types and sizes

Figures in boxes below show square inches of free louver area.

### flush panel

| DOOR HEIGHT | DOOR WIDTH | F     | V  | VL  | L      | TL     | DL     | FL     | FG |
|-------------|------------|-------|----|-----|--------|--------|--------|--------|----|
|             |            | 5 1/2 | 10 | 10  | 14 1/4 | 14 1/4 | 14 1/4 | 14 1/4 | 28 |
| 6' 8"       | 2' 0"*     |       |    | 124 | 124    | 124    | 248    |        |    |
|             | 2' 4"      |       |    | 167 | 167    | 167    | 334    |        |    |
|             | 2' 6"*     |       |    | 188 | 188    | 188    | 376    |        |    |
|             | 2' 8"*     |       |    | 209 | 209    | 209    | 418    | 915    |    |
|             | 3' 0"*     |       |    | 252 | 252    | 252    | 504    | 1096   |    |
|             | 3' 4"*     |       |    | 294 | 294    | 294    | 588    |        |    |
|             | 3' 6"*     |       |    | 315 | 315    | 315    | 630    |        |    |
| 7' 0"       | 2' 0"**    |       |    | 124 | 124    | 124    | 248    |        |    |
|             | 2' 4"      |       |    | 167 | 167    | 167    | 334    |        |    |
|             | 2' 6"*     |       |    | 188 | 188    | 188    | 376    |        |    |
|             | 2' 8"*     |       |    | 209 | 209    | 209    | 418    | 1170   |    |
|             | 3' 0"*     |       |    | 252 | 252    | 252    | 504    | 1368   |    |
|             | 3' 4"*     |       |    | 294 | 294    | 294    | 588    |        |    |
|             | 3' 6"*     |       |    | 315 | 315    | 315    | 630    |        |    |
|             | 3' 8"*     |       |    | 336 | 336    | 336    | 672    |        |    |
|             | 4' 0"**    |       |    | 378 | 378    | 378    | 756    |        |    |

\*Inactive leaf available. Includes wrap-around astragal and top and bottom flush bolts.

Also available as blank stile doors for use with push plates or rim-type panic devices.

### recessed panel

| DOOR HEIGHT | DOOR WIDTH | RP | RV | RVL | RL | RTL | RDL |
|-------------|------------|----|----|-----|----|-----|-----|
| 6' 8"       | 2' 0"*     |    |    | 32  | 32 | 32  | 64  |
|             | 2' 4"**    |    |    | 32  | 32 | 32  | 64  |
|             | 2' 6"*     |    |    | 32  | 32 | 32  | 64  |
|             | 2' 8"*     |    |    | 64  | 64 | 64  | 128 |
|             | 3' 0"*     |    |    | 64  | 64 | 64  | 128 |
|             | 3' 4"*     |    |    | 64  | 64 | 64  | 128 |
|             | 3' 6"*     |    |    | 64  | 64 | 64  | 128 |
| 7' 0"       | 2' 0"**    |    |    | 32  | 32 | 32  | 64  |
|             | 2' 4"**    |    |    | 32  | 32 | 32  | 64  |
|             | 2' 6"*     |    |    | 32  | 32 | 32  | 64  |
|             | 2' 8"*     |    |    | 64  | 64 | 64  | 128 |
|             | 3' 0"*     |    |    | 64  | 64 | 64  | 128 |
|             | 3' 4"*     |    |    | 64  | 64 | 64  | 128 |
|             | 3' 6"*     |    |    | 64  | 64 | 64  | 128 |
|             | 3' 8"*     |    |    | 64  | 64 | 64  | 128 |
|             | 4' 0"**    |    |    | 64  | 64 | 64  | 128 |

\*Inactive leaf available. Includes wrap-around astragal and top and bottom flush bolts.

Also available as blank stile doors for use with push plates or rim-type panic devices.

*Underwriters' Laboratories, Inc.*  
INSPECTED

Commercial Line flush panel type doors can be supplied in 2' 6" to 4' 0" widths with Underwriters' Laboratory Inspection labels. Flush panel doors (F) are available with 3-hour "A" labels or 1 1/2 hour "B" labels. Vision panel doors (V) are available with 1 1/2 hour "B" labels, and half-glass doors (G) are available with 3/4 hour "C" labels.

### standard door glass sizes — flush & recessed doors

| DOOR HEIGHT | DOOR WIDTH | FG              | G & RG      | G2 & RG2        | G3 & RG3        | G4 & RG4     |
|-------------|------------|-----------------|-------------|-----------------|-----------------|--------------|
| 6' 8"       | 2' 4"      |                 | 17 3/8 x 32 | 17 3/8 x 15 3/8 | 17 3/8 x 10 3/8 | 7 1/2 x 15%  |
|             | 2' 6"      |                 | 19 3/8 x 32 | 19 3/8 x 15 3/8 | 19 3/8 x 10 3/8 | 9 1/2 x 15%  |
|             | 2' 8"      |                 | 21 3/8 x 32 | 21 3/8 x 15 3/8 | 21 3/8 x 10 3/8 | 10 1/2 x 15% |
|             | 3' 0"      | 25 3/8 x 65 1/2 | 25 3/8 x 32 | 25 3/8 x 15 3/8 | 25 3/8 x 10 3/8 | 12 1/2 x 15% |
|             | 3' 4"      | 29 3/8 x 65 1/2 | 29 3/8 x 32 | 29 3/8 x 15 3/8 | 29 3/8 x 10 3/8 | 14 1/2 x 15% |
|             | 3' 6"      | 31 3/8 x 65 1/2 | 31 3/8 x 32 | 31 3/8 x 15 3/8 | 31 3/8 x 10 3/8 | 15 1/2 x 15% |
| 7' 0"       | 2' 6"      |                 | 19 3/8 x 36 | 19 3/8 x 17 3/8 | 19 3/8 x 11 1/2 | 9 1/2 x 17%  |
|             | 2' 8"      |                 | 21 3/8 x 36 | 21 3/8 x 17 3/8 | 21 3/8 x 11 1/2 | 10 1/2 x 17% |
|             | 3' 0"      | 25 3/8 x 69 1/2 | 25 3/8 x 36 | 25 3/8 x 17 3/8 | 25 3/8 x 11 1/2 | 12 1/2 x 17% |
|             | 3' 4"      | 29 3/8 x 69 1/2 | 29 3/8 x 36 | 29 3/8 x 17 3/8 | 29 3/8 x 11 1/2 | 14 1/2 x 17% |
|             | 3' 6"      | 31 3/8 x 69 1/2 | 31 3/8 x 36 | 31 3/8 x 17 3/8 | 31 3/8 x 11 1/2 | 15 1/2 x 17% |
|             | 3' 8"      | 33 3/8 x 69 1/2 | 33 3/8 x 36 | 33 3/8 x 17 3/8 | 33 3/8 x 11 1/2 | 16 1/2 x 17% |
|             | 4' 0"      |                 | 37 3/8 x 36 | 37 3/8 x 17 3/8 | 37 3/8 x 11 1/2 | 18 1/2 x 17% |



Figures in boxes below show square inches of free louver area.

| G      | GL | G2 | G3 | G4    |
|--------|----|----|----|-------|
| 41 1/2 | 28 |    |    | 5 1/2 |
| 383    |    |    |    |       |
| 427    |    |    |    |       |
| 512    |    |    |    |       |
| 598    |    |    |    |       |
| 641    |    |    |    |       |
| 383    |    |    |    |       |
| 427    |    |    |    |       |
| 512    |    |    |    |       |
| 598    |    |    |    |       |
| 641    |    |    |    |       |
| 685    |    |    |    |       |
| 772    |    |    |    |       |

Half-glass doors convert in field to multi-light designs shown above.

| RG     | RGL | RG2 | RG3 | RG4 |
|--------|-----|-----|-----|-----|
| 41 1/2 |     |     |     |     |
| 64     |     |     |     |     |
| 128    |     |     |     |     |
| 128    |     |     |     |     |
| 128    |     |     |     |     |
| 128    |     |     |     |     |
| 64     |     |     |     |     |
| 128    |     |     |     |     |
| 128    |     |     |     |     |
| 128    |     |     |     |     |
| 128    |     |     |     |     |
| 128    |     |     |     |     |

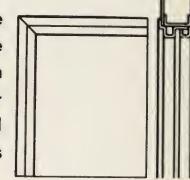
Half-glass doors convert in field to multi-light designs shown above.

sizes available.

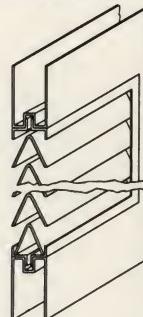
Types and sizes in shaded blocks are available for fast delivery when prepared for 161 Series locks.

### vision panels

Doors with vision lights have light centered between the stiles, positioned 5' 3" from bottom of door to center line of vision light. Exposed glass is 10" x 10". Frame is simple, clean design.



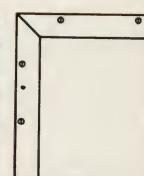
### louvers



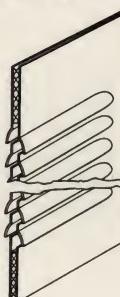
All flush panel doors have inverted V-type louvers which laterally fill space between stiles. Except in half-glass and full louvered doors, louvers are 14 1/4" high. Bottom louver in the full louvered doors and in half-glass doors are 28" high. Top and bottom louver in the full louvered doors are separated by a 5 1/2" center rail.

### vision panels

Recessed Panel doors are available with vision lights centered between stiles in the upper panel, positioned 5' 3" from bottom of door to center line of vision light, regardless of door height. Exposed glass is 10" x 10".



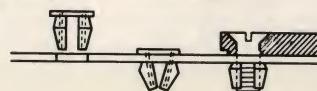
### louvers



In Recessed Panel doors, louvers are of the pierced type, as shown in illustration (left). 2' 0" and 2' 6" doors have louvers 9" x 13 1/8", larger doors have louvers 18" x 13 1/8".

### miscellaneous hardware

Mounting of closers and other surface-applied hardware, is performed in the field by use of "Banc-Lok" nuts, supplied by Amweld. These are hand-inserted in holes drilled at proper locations for receipt of mounting screws, making special reinforcements unnecessary.





**steel folding closet door units**



### **louvered design**

#### **FREE CIRCULATION**



Louvered area permits circulation of fresh air to closet interior. Prevents mildew, particularly in humid climates.

#### **KEEPS DIRT OUT**



Solid lower panels keep out dust from sweeping. Clothes stay clean longer—free from intruding dust and lint.

#### **SOUND DEADENED**



The molding surrounding louvered area is repeated on lower panel—effectively sound deadens each panel. Makes the Prestige Line folding door extremely quiet in operation.

#### **EASY OPERATION**



Prestige Line units operate smoothly on lifetime nylon pivots. Open and close at finger-tip touch.

### **suggested applications** for folding closet door units



**ATTICS**



**GARAGES**



**WARDROBES**



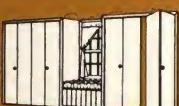
**CUPBOARDS**



**BASEMENTS**



**CLOSETS**



**BEDROOMS**

### **series 500**

## **Prestige Line**

### **louvered panels**

#### **colonial styling**

These precision-made louvered closet units lend classic beauty to any style interior. They are particularly well suited to entry way closets, bedroom wardrobes, or wherever the convenience of folding doors is desired and a decorator touch is called for. Top half is louvered. Attractive molding surrounds louvered area and conceals all edges.

#### **sizes**

Prestige Line units are available in 6' 8" and 8' 0" high, in 3' 0", 4' 0", 5' 0" and 6' 0" widths. Furnished as a package, complete with brass door pulls, upper and lower track and all hardware required.

#### **antique ivory finish**

Prestige units come ready to install. Factory applied, baked-on enamel finish requires no additional painting—or can serve as base coat where different color is desired.

# series 500 Commodity Line

## folding closet units

### standard 6' 8"

Standard height folding door units can be trimmed to match height of standard door openings. Finished with rust-inhibiting prime coat, ready for painting.

### king-size 8' 0" saves money

Also available in 8' 0" high, king-size units. This floor-to-ceiling unit provides additional overhead storage. Eliminates extra cost of building wall down from ceiling. Ideal for wardrobes, closets and, when used as multiple units, can make a complete storage wall in basement, multi-purpose room, or garage.

### packed in single carton

Amweld folding closet door units are packed singly in carton. Each carton contains panels, tracks, handles, and all hardware required for installation. Single opening units (two panels) are available and are also packed singly.

### architect's specifications

#### folding closet units series 500

#### prestige line or commodity line

**Panels**—Panels shall be of 24 gauge steel formed at the edges to give maximum rigidity and shall contain top and bottom horizontal stiffeners. Flush panels furnished with sound-deadening material for quiet operation.

**Top and Bottom Track** shall be formed of heavy gauge metal and fitted with anti-friction bearings at pivot points.

Guides and pivots to be of long-wearing, low-friction material. Each panel shall be reinforced with metal stiffeners and fitted with attractive finger pulls. Furnished with baked-on neutral color prime coat electrostatically applied and controlled.

**Option**—18 gauge "K-D" steel frames formed to Amweld standard profiles shall be used to mount folding door units.

**FINISH**—All exposed surfaces shall be primed with a neutral color, rust-inhibiting, baked-on synthetic enamel, electrostatically applied and controlled.

### sizes

#### series 500 folding closet units

|                   | COMMODITY LINE    |                    |                                | PRESTIGE LINE             |
|-------------------|-------------------|--------------------|--------------------------------|---------------------------|
|                   | 6' 8"<br>Standard | 8' 0"<br>King Size | 6' 8" & 8' 0"<br>Full Louvered | 6' 8" & 8' 0"<br>Louvered |
| Double<br>Opening | 3' 0"             | 3' 0"              | 3' 0"                          | 3' 0"                     |
|                   | 4' 0"             | 4' 0"              | 4' 0"                          | 4' 0"                     |
|                   | 5' 0"             | 5' 0"              | 5' 0"                          | 5' 0"                     |
|                   | 6' 0"             | 6' 0"              | 6' 0"                          | 6' 0"                     |
| Single<br>Opening | 1' 6"             | 1' 6"              | 1' 6"                          | 1' 6"                     |
|                   | 2' 0"             | 2' 0"              | 2' 0"                          | 2' 0"                     |
|                   | 2' 6"             | 2' 6"              | 2' 6"                          | 2' 6"                     |
|                   | 3' 0"             | 3' 0"              | 3' 0"                          | 3' 0"                     |
|                   |                   |                    |                                |                           |

Available for fast delivery.



### flush panels

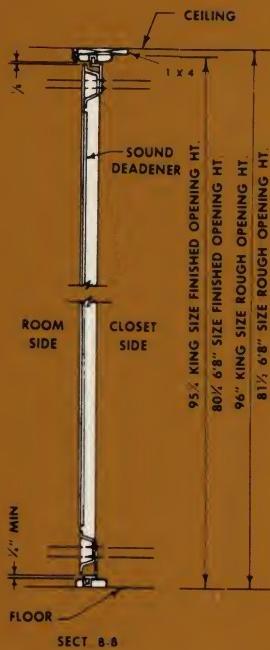
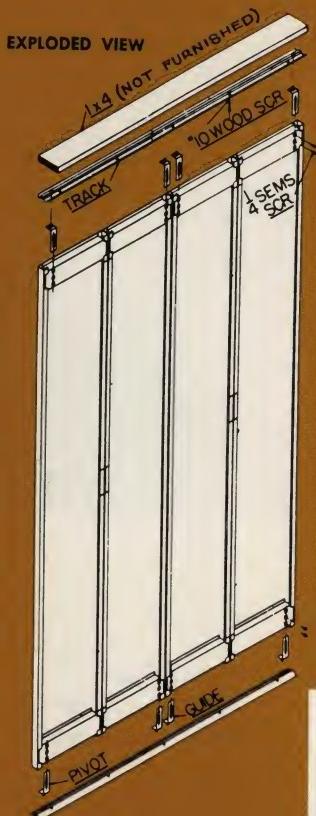
The most convenient door for any closet, wardrobe or storage area. Provides full access without sacrificing valuable floor space. Consists of four panels, hinged in pairs. Doors open by folding to each side. The 3' unit projects about 5" into room when opened, the 4' only 7", the 5' only 9" and the 6' unit 11". Unit is sound deadened and operates smoothly on self-lubricating nylon pivots.



### full louvered panels

Amweld 6' 8" and 8' 0" high folding door units are now available fully louvered top-to-bottom with decorative center rail. Provides attractive and practical closet closure, particularly for humid climates. Keeps dust out and permits ventilation.

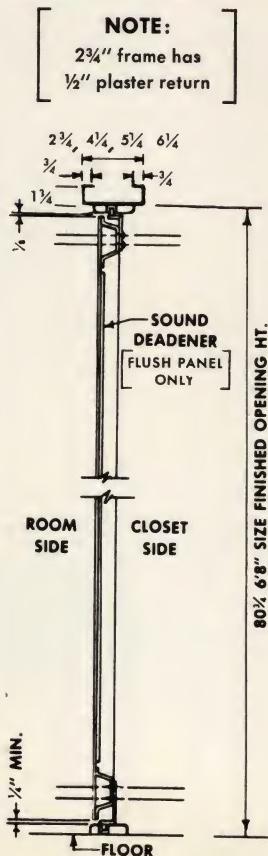
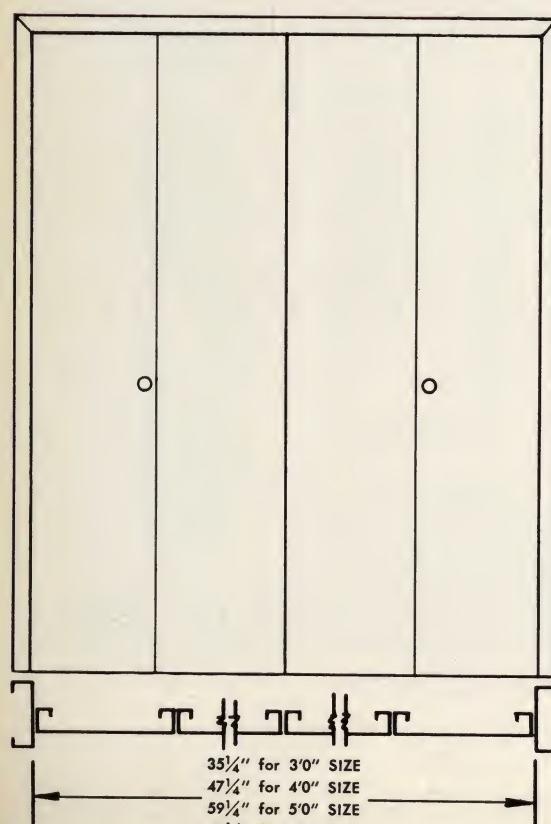
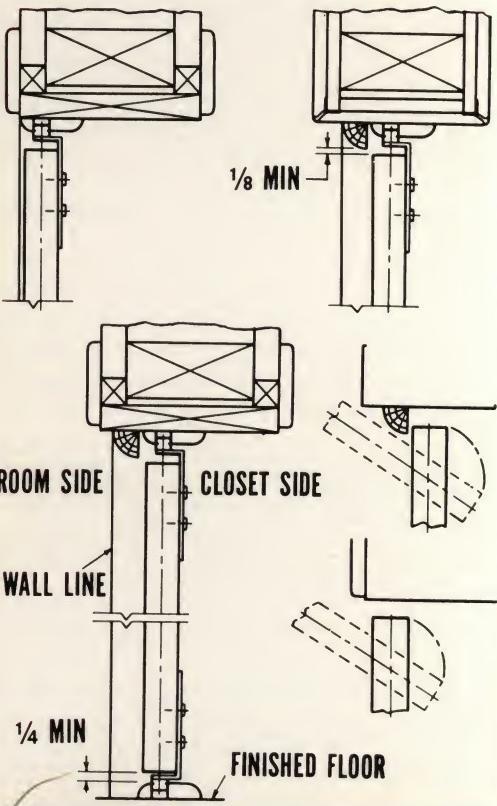
**AMWELD** "K-D" steel folding closet door units



**easy installation**

These units can be installed by any workman in minutes. Screw driver is only tool needed.

**optional methods of trim**



**series 500**

**Commodity Line  
framed steel folding  
door units**

Steel frames for trimming opening and folding closet door units can be furnished as a complete unit. Requires no facing trim. Consists of 2 jambs and 1 header, top and bottom track, panels, handles and all hardware required for installation.

| SIZES          | Commodity Line<br>6' 8" Flush Panel | Prestige and<br>Commodity Line<br>6' 8" Louver Design |
|----------------|-------------------------------------|---|
| DOUBLE OPENING | 3' 0"<br>4' 0"<br>5' 0"<br>6' 0"    | 3' 0"<br>4' 0"<br>5' 0"<br>6' 0"                      |
| SINGLE OPENING | 2' 0"<br>2' 6"<br>3' 0"             | 2' 0"<br>2' 6"<br>3' 0"                               |

# E-Z frames for wood doors

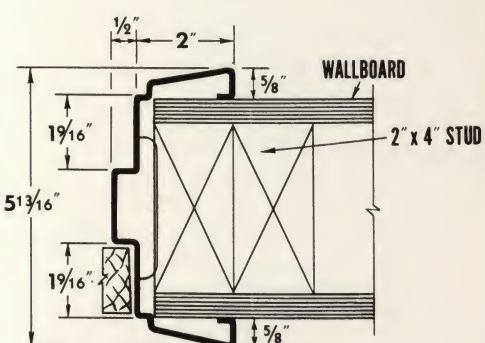
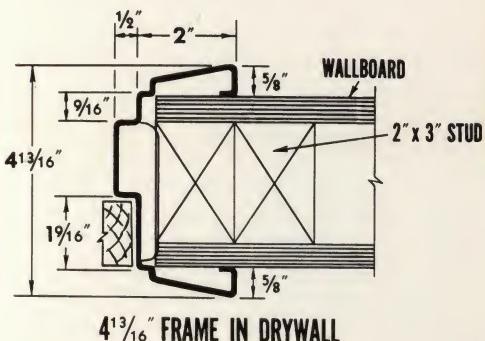


16b  
Amw



## installation details

scale (3"=1')



## sizes

| Frame Height | Opening | Frame Height | Opening |
|--------------|---------|--------------|---------|
| 6' 6"        | 1' 6"   | 6' 8"        | 1' 6"   |
|              | 2' 0"   |              | 2' 0"   |
|              | 2' 2"   |              | 2' 2"   |
|              | 2' 4"   |              | 2' 4"   |
|              | 2' 6"   |              | 2' 6"   |
|              | 2' 8"   |              | 2' 8"   |
|              | 3' 0"   |              | 3' 0"   |

ALL SIZES AVAILABLE FOR  
FAST DELIVERY.

## heavy gauge steel

Made of 22 gauge rust-resistant steel.

## installs over drywall

Fast, economical method of framing room opening. Requires one man less than 15 minutes to install. Eliminates mortising, drilling and fitting of jambs.

## attachment

Frames are securely anchored to studs by use of wood screws through the hinges and strike plates. Wall anchors at the base of jambs keep frame plumb. (Base anchors are covered by base mouldings.)

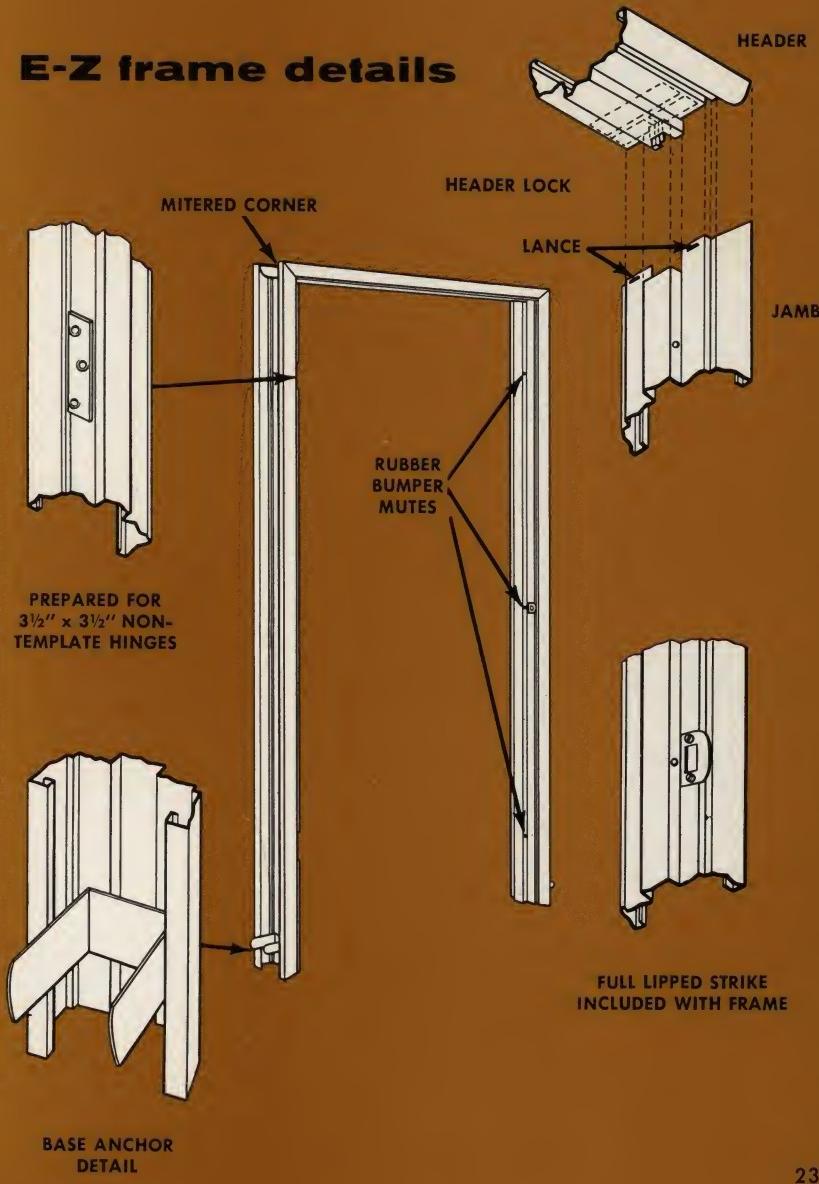
## mitered corners

Frames are self aligning, mitered corners present neat, hairline closure.

## ready to paint

E-Z Frames are specially treated at factory to prepare surface for painting. Require no special priming.

## E-Z frame details





**Quality  
Guarantee**

\*

This steel door and  
or frame meets all  
requirements of the  
applicable Commercial  
Standard, CS211-  
57, CS212-57, or  
CS213-57, issued by  
the U. S. Department  
of Commerce.

BY

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PLANT STREET, NILES, OHIO

A Division of The American Welding & Manufacturing Co., Warren, Ohio

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